

hot runner user manual



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Section 1 - Introduction

We would like to take this opportunity to thank you for purchasing a *Mold-Masters* hot runner.

The purpose of this manual is to assist users in the integration, operation and maintenance of *Mold-Masters* systems. This manual is designed to cover most system configurations. For additional information, please contact your representative or a *Mold-Masters* office.

Please note that the responsibility for the safety of personnel remains exclusively with the employer. It is the obligation of the employer to properly train and instruct its personnel in the safe operation of equipment including maintenance and the purpose and proper use of all the safety devices. In addition, the employer must provide its personnel with all necessary protective clothing, including such items as a face shield and heat resistant gloves. Any instructional material provided by *Mold-Masters* for the operation and maintenance of equipment, does not in any way absolve the employer from fulfilling these obligations and *Mold-Masters* disclaims liability for injury to personnel using equipment supplied.

Warranty and Documentation

Your original system documentation contains warranty details. If for any reason, parts must be returned to *Mold-Masters*, it is essential to obtain prior pre-authorization and a return authorization number.

Documentation will include any or all of the following:

- Parts list containing all system components. Together with the general assembly drawing, the parts list should be referenced when ordering spare parts.
- General assembly drawing used to integrate your hot runner system into mold.
- Hot half drawing used to integrate hot half to cavity plate.

When ordering this manual, please reference document number: **HRUMENXXLT_13**.

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NOTE

This manual should be used in conjunction with any appropriate Temperature Controller User Manual.

Trademarks and Patents

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Section 3 - Safety

Introduction

High injection pressures and high temperatures are used in the operation of hot runners. To protect the operator in the work place, ensure that all safety devices are installed on the machine.

- Be aware of all warning labels attached to the mold and machine.
- Refer to the machine user manual for safety procedures and checks not included here in the hot runner specific manual.

Notices

To make the manual easier to use, we have included notices throughout that highlight important information. See below.



WARNING

Safety warning indicates a potentially hazardous situation, which if not avoided, could result in serious injury or death.



CAUTION

Caution indicates that damage to equipment is possible if instruction is not followed.



NOTE

Note indicates useful additional information or is used as a reminder of important information.

General Safety Warnings



The equipment supplied is subjected to high injection pressures and high temperatures. Ensure that extreme caution is observed in the operation and maintenance of the hot runner system and the injection molding machines.

- Do not operate the equipment with unconfined long hair, loose clothing or jewelry, including name badges, neckties, etc. These may get caught by the moving belt mechanism and can cause death or serious injury.
- Never disable or bypass a safety device.
- It is highly recommended that all operators wear face shields and use heat resistant gloves when working around the feed throat, purging the machine or cleaning the gates of the mold.
- Check frequently for possible oil leaks/water leaks. Stop the machine and make repairs.
- Remove purgings from the machine immediately.
- Never touch or inspect the timing belt when power is on and motor and controller are connected. Unplug the controller before any maintenance.
- Always cover belt area with proper protecting sheet before any bench test or in-mold testing.
- High voltage and amperage cables are connected to the controller (220VAC). There is also a high voltage cable connection between servo motor and controller.
- Unplug the controller before performing any maintenance work.

General Safety Warnings - Con't



- Hoses fitted to the mold will contain high or low temperature fluids or air under high pressure. The operator must shut down and lockout these systems as well as relieving any pressure before performing any work with these hoses.
- Never perform any work on the mold unless the hydraulic pump has been stopped.
- High voltage and amperage cables are connected to the mold. Electric power must be shut off prior to installing or removing any cables.
- Water and or hydraulics on the mold may be in close proximity to electrical connections and equipment. Water leakage may cause an electrical short circuit. Hydraulic fluid leakage may cause a fire hazard. Always keep water and /or hydraulic hoses and fittings in good condition to avoid leaks.
- All maintenance on *Mold-Masters* products should be performed by properly trained personnel based on local law or regulation requirements. Electrical products may not be grounded when removed from the assembled or normal operating condition. Ensure proper grounding of all electrical products before performing any maintenance to avoid potential risk of electrical shock.

Operating the Mold



Check that all coolant, hydraulic and air lines as well as electrical cables will not interfere with the moving parts of the mold, machine or robot. The lines must be of sufficient length so that they will not strain or pinch when the mold halves separate.

- For water-cooled gate inserts, coolant must be maintained with the proper mixture to prevent corrosion and circuit blockage.
- Care must be taken to ensure the nozzle terminal ends do not come in contact with the hydraulic fluid. The nozzles may short out or become damaged.
- Do not mix electrical power cables with thermocouple extension cables. They are not designed to carry the power load or list accurate temperature readings in each other's application.

Heater Element



To maximize heater element and component life, the temperature must be controlled and maintained within safe operating limits. *Mold-Masters* strongly recommends individual control of each heated component, including heater plates, with a reliable temperature controller that includes soft-start protection.

All *Mold-Masters* heated components are manufactured to standards that ensure safe and reliable operation provided that the following precautions are met:

- Always operate the system using correctly installed "J" type thermocouples connected to a reliable temperature controller with "soft-start" protection.
- Avoid running the system for long periods on "manual" control.
- Use caution when applying power in "manual" mode. Use minimum heat required for the process to avoid overheating and possible damage to components.
- Always replace pinched or damaged thermocouples.
- When "grouping" heated components together and controlling more than one load from a single thermocouple, make sure that the components are of similar material, wattage, size and are exposed to the same thermal conditions.
- When replacing heater plates or other heated components always replace with *Mold-Masters* components of the same type and install as originally specified on *Mold-Masters* general assembly drawings.

Section 4 - Preparation

Introduction

The following section is a step-by-step guide to preparing your *Mold-Masters* system for use.

Screw Lengths



WARNING

The use of an incorrect size, length and grade screw could cause the screw to shear, fatigue or stretch beyond its yield point, resulting in expensive downtime of the hot runner.

Be aware of warnings placed on the assembly drawings. When the manifold is heated the metal expands stretching the mounting screws, if screw lengths are shortened there is a possibility of shearing.

The expansion factor is calculated into the length of each screw size.

WARNING
DO NOT SHORTEN SCREW

S.H.C.S. M12 X 130
(ISO-GRADE 12.90
OR ½ - 13 X 4.75
(ASTM A574)
NOT SUPPLIED BY
MOLD-MASTERS

EXAMPLE

24	030-2529	HOUSING 48 POLE MOUNTING
23	030-2518	24 POLE FEMALE
22	030-2520	24 POLE MALE
21	SHCS1/4-20X.75	SOCKET HEAD CAP SCREW, 1/4-20 X 0.75" L
20	NUT1/4	HEX NUT, 1/4"
19	ELB008B	ELECT. BOX, (HOFFMAN 8-BAS 85C MODIFIED)
18	SHCS1/4-20X.625	SOCKET HEAD CAP SCREW, 1/4-20 X 0.625" L
17	50063	LOCKWASHER, 1/4"
16	WASHER1/4	WASHER, 1/4"
15	NP0007	START-UP PROTECTURE PLATE FOR MELT DISK ASSY
14	RS4X1/4	RIVET SCREW
13	NP0002	NAME PLATE
12	PP1/4-18	PIPE PLUG, UNBRAID # 05766, 1/4-18 NPT
11	JPT1/4-18X.275	JIFFY PLUG, DME #JP-352, 1/4-18 NPT
10	SPACER	NOZZLE PROTECTION SPACER
9	PROD19-A	WIRE RETAINER,
8	FHS1/4-20X.50	FLAT HEAD CAP SCREW, 1/4-20 X 0.50" L
7	SHCS5/16-18X1.0	SOCKET HEAD CAP SCREW, 5/16-18 X 1.00" L
6	SHCS1/2-13X1.50	SOCKET HEAD CAP SCREW, 1/2-13 X 1.50" L
5	SHCS5/8-11X4.0	SOCKET HEAD CAP SCREW, 5/8-11 X 4.00" L

Tools Required

Depending on the size and complexity of your hot runner system, you will require most of the tools and materials listed below.

- Allen keys - Set of imperial size keys and metric sizes 4, 5, 6, 8 and 10 mm for use on both imperial and metric cap screws (depending on system).
- Nickel based anti-seize compound - To prevent oxidation of screw threads that could cause screws to seize with high temperatures.
- Solvents (denatured alcohol) - For removal of rust inhibitors.
- Calibrated torque wrench - For consistent screw pressure throughout the system.
- Pliers - For general assembly work.
- Circlip pliers - To remove and install Circlip in valve systems.
- Micrometer - (sizes 0 - 6" and 0 - 150 mm) To check system part and plate thickness.
- Depth micrometer - To check bore depths.
- Slot head screw driver - Used in installing thermocouples and ground wires.
- Slot head screw driver (small) - Used in fastening electrical wires to connectors.
- Crimping tool - For fastening connector pins when necessary.
- Wire strippers - For preparing wires.
- Utility knife - For cutting tape, wires etc.
- Glass tape - Used for grouping wires into zones.
- Bluing Compound - For checking face contact.
- Sockets.
- Lapping compound for valve gate systems.
- Plastic face hammer.
- Proper actuator installation / extraction tools.

Unpacking

1. Carefully remove all components from the shipping box and check that all components listed on the packing slip were supplied.
2. Check that all mold base dimensions are correct and correspond to *Mold-Masters* general assembly drawings.



Cleaning

All nozzles, manifolds and hot runner components must be free of the rust inhibitor applied at the factory.

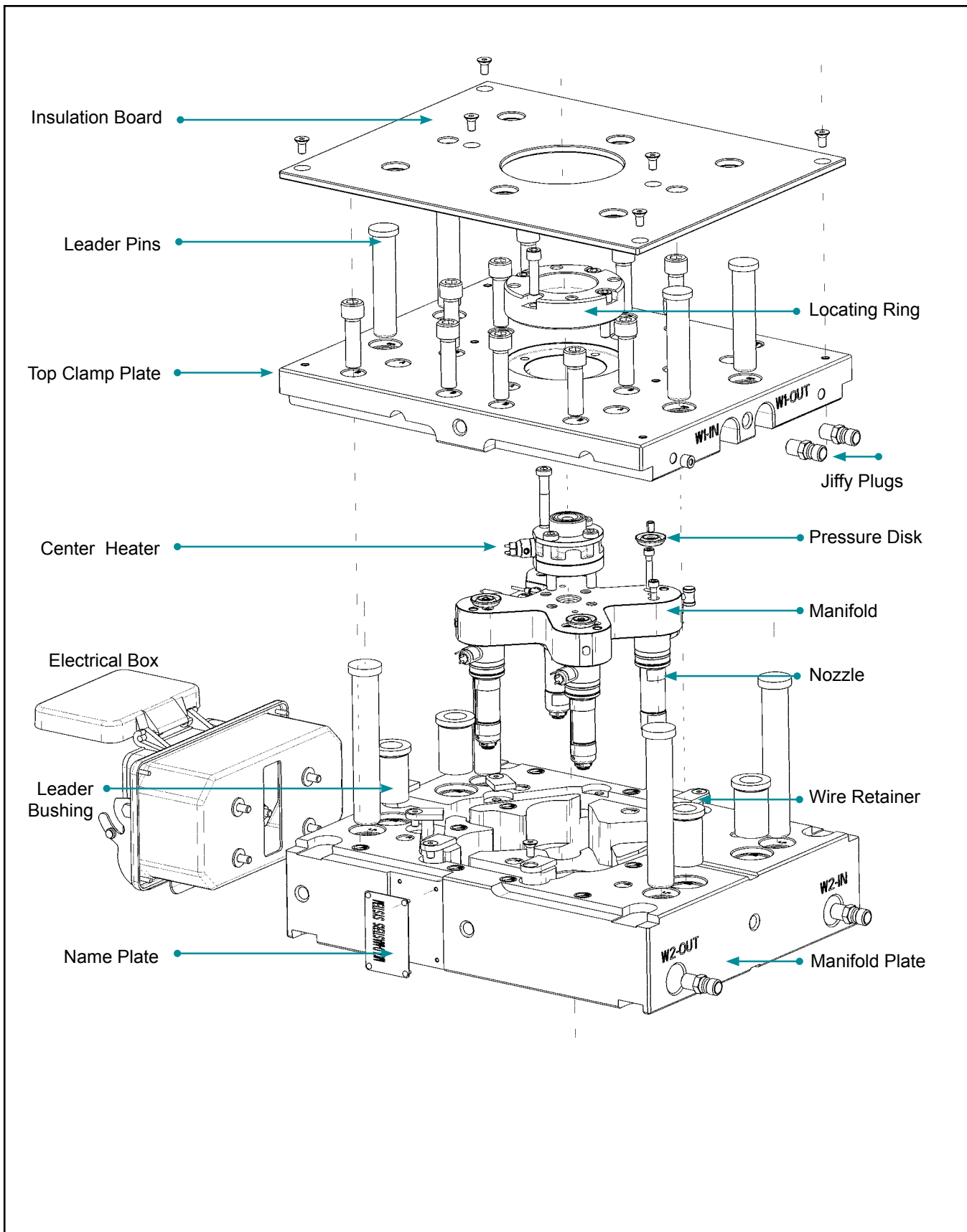
1. Disassemble the system.
2. Wipe down the nozzle body.
3. Remove the part and wipe clean.
4. If necessary, use a cotton swab to clean the narrow interior surfaces or screw threads. For large surfaces such as mold plates, use thinner in spray form to clean channels and recesses.

Establishing Your System Type

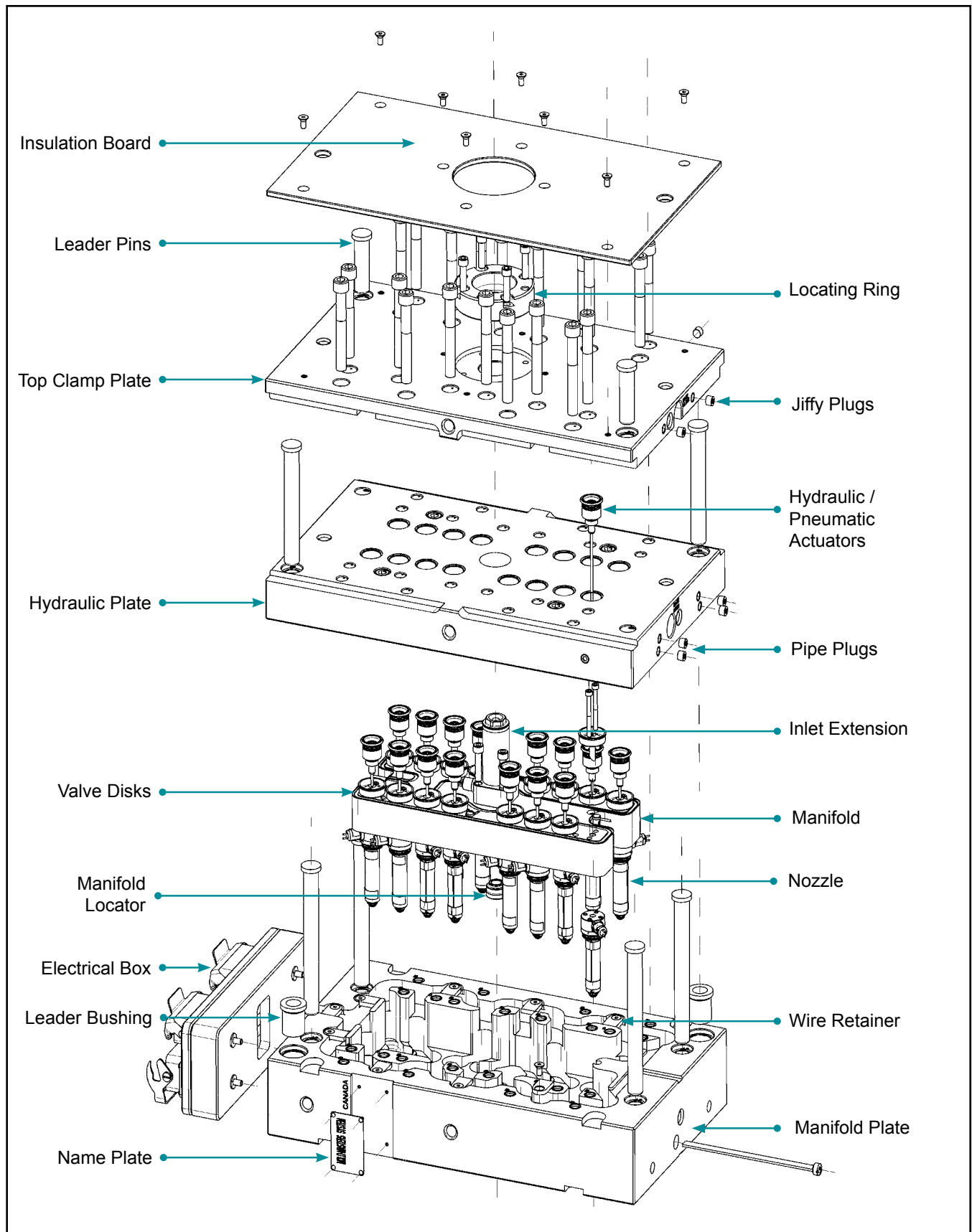
The following pages are to be used as a general guide to assist in identifying components. Refer to your general assembly drawings for specific component lists.

If your system does not match these systems, please refer to other specialty systems mentioned within the manual for additional information.

System With Cast In Heater Element

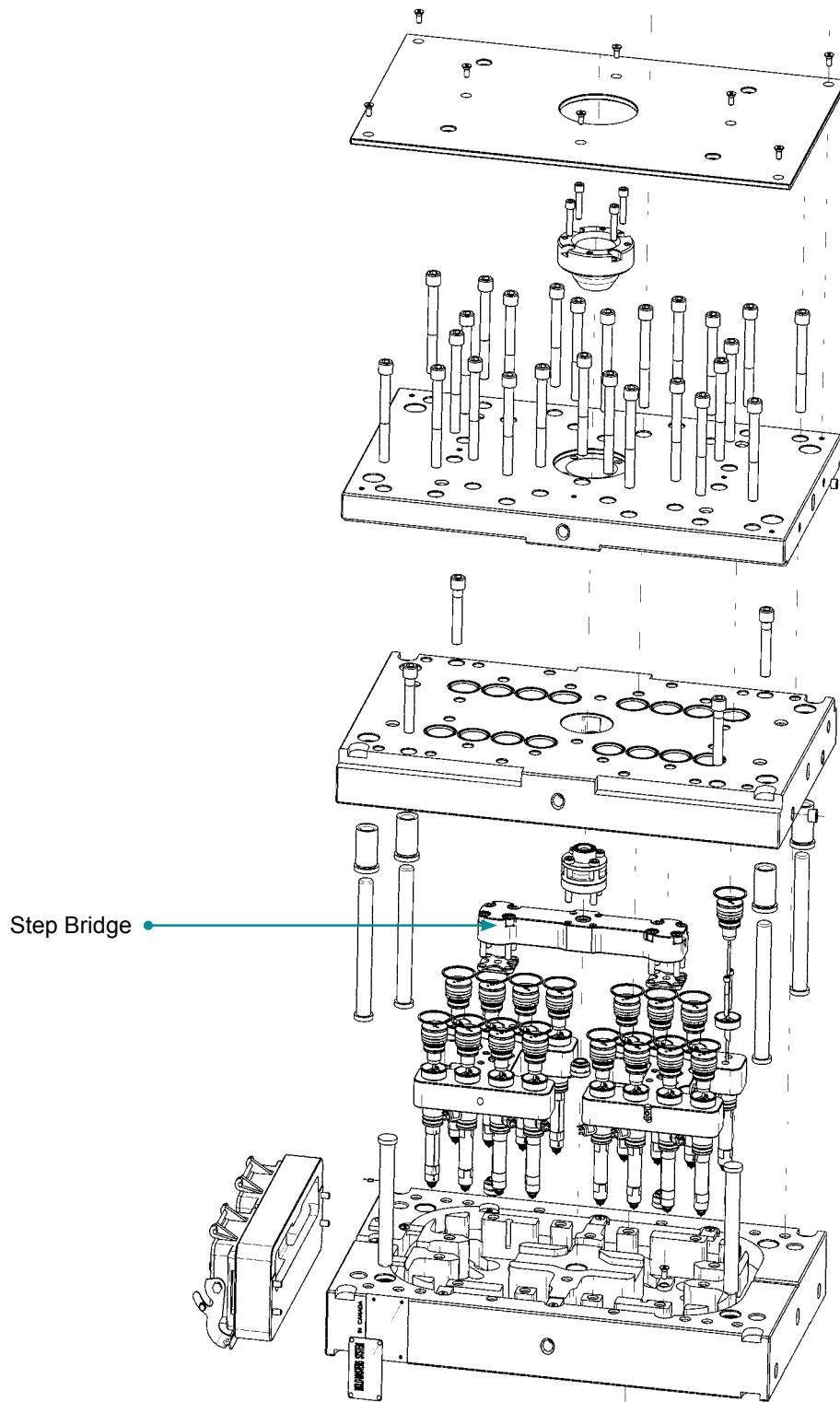


System With Hydraulic Or Pneumatic Units



System with Bridged Hydraulic Pneumatic System

Components identical to previous page.



Section 5 - Assembly

Introduction

This section is a step-by-step guide to assembling your *Mold-Masters* hot runner system.

Gate Seal Finishing

Most nozzles are supplied with the gate seal installed (except when the seal requires final machining by a toolmaker, such as the hot valve or hot sprue).



NOTE

The gate seals supplied with your system may need to be adjusted to tolerances based on the material grade and cooling in the cavity. Refer to your *Mold-Masters* General Assembly Gate Detail drawing to determine if gate seal finishing is required. Refer to the general assembly drawing to determine which gating method applies.

Hot Valve / Hot Sprue / F Type

Hot valve and hot sprue gated systems are supplied with gate seals that are oversize in length. They must be machined prior to installing the nozzle into the nozzle well bore.



NOTE

Hot sprue also requires completion of the gate detail. Refer to the nozzle well detail drawing.



NOTE

Heat expansion of the nozzle must also be taken into consideration.

Check the chart on the general assembly drawings for the length and contact height required.

See contact length "H" on table below.



CAUTION

Ensure the thermocouple is not damaged during machining.

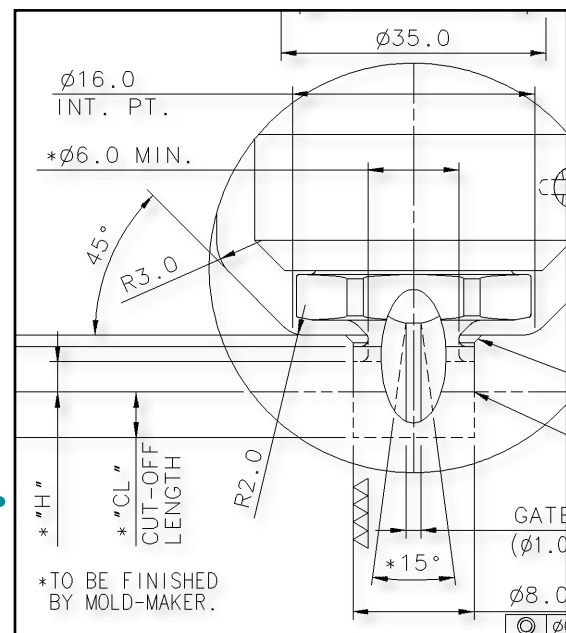


Figure 5-1 Hot Valve / Hot Sprue Gated System

Polymer Structure	Contact Length "H"
Amorphous Filled or Reinforced	4.00
Semi-crystalline Filled or Reinforced	3.00
Crystalline Filled or Reinforced	2.00

Water-cooled Gate Insert Installation (Option)

Your system may not include a water-cooled gate insert. Refer to your general assembly drawing.

The water-cooled gate insert will require final machining.

1. Machine the water-cooled gate insert to final height and then add the gate detail. Refer to your system drawing for details.
2. Clean the insert-seating bore.
3. Install O-rings onto the water-cooled gate insert.

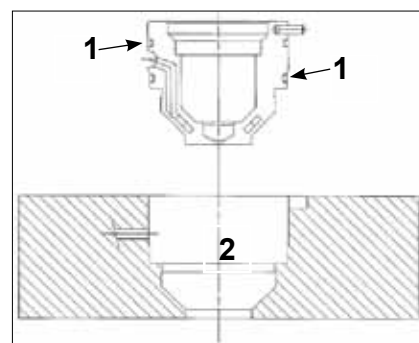


Figure 5-2 Water-cooled Gate Insert
1. O-Rings 2. Seating Bore

Master-Series Thermocouple Installation

1. Clean the nozzle thermocouple bore.
Suggestion, for:
 - 1 mm thermocouples use a #58 drill in a pin vise
 - 1.5 mm thermocouples use a 1/16 inch drill in a pin vise



Figure 5-3 Clean thermocouple bore

2. Insert the thermocouple through the flange bore.



Figure 5-4a



Figure 5-4b

3. Manually bend the thermocouple tip against your thumb to approximately a 90° angle, ensuring bend length is sufficient to reach the bottom of the thermocouple bore.



Figure 5-5a



Figure 5-5b

Master-Series Thermocouple Installation - con't.

4. Dress thermocouple carefully alongside nozzle body and install retaining clip(s). Check parts list for recommended number of clips for the nozzle type. Check that the thermocouple fits into the recess of the clip. It is important that one retainer clip is at the top of the nozzle to keep the thermocouple inside the bore. This is especially important when thermocouples are assembled from the front.



Figure 5-6

5. Install the terminal end retaining clip. Check that the thermocouple fits into the recess of the clip.

IMPORTANT: Ensure the terminal end of the thermocouple stays fully engaged in the slot while bending the thermocouple at the nozzle flange area.



Figure 5-7

6. Install the clip over the terminal end.



Figure 5-8

7. Use heat resistant tape to secure the nozzle wires and thermocouple wires just above or below the insulator pod.



Figure 5-9

Master-Series Thermocouple Removal

(for non-front mounted thermocouples)

NOTE: Removing thermocouples will damage them and is not recommended unless replacing a damaged thermocouple with a replacement one.

1. Remove the thermocouple from the electrical box and wire channels.
2. Remove the nozzle from the manifold plate.
3. Remove the thermocouple retaining clips.
4. Remove the thermocouple.

Dura Line Thermocouple Installation

This page only applies to Legacy Dura Nozzles.

Mold-Masters Dura systems are supplied with an appropriate bending tool. Any questions regarding bending tools, please contact your *Mold-Masters* representative. Make sure that correct bending tool is used. Each different type of Dura nozzle requires a different bending tool. The correct bending tool was supplied with your hot runner.

1. Clean nozzle thermocouple bore.
Place thermocouple through the flange of the nozzle.



Figure 5-10a



Figure 5-10b

2. Place the end of the bending tool all the way over the end of the thermocouple. While supporting the thermocouple, create a 180° “fish hook” with the tool. Make sure the bending tool is snug up against the thermocouple.



Figure 5-11a



Figure 5-11b

3. Insert the bent thermocouple end into the nozzle mating hole and make sure it is fully engaged.



Figure 5-12

Dura Line Thermocouple Installation - con't.

4. Make sure the thermocouple is fully engaged in the nozzle body while bending the thermocouple at the flange.



Figure 5-13a



Figure 5-13b

5. Press thermocouple downwards to sit against terminal end and secure to side of terminal end with heat resistant tape to ensure it does not become pinched between the nozzle and the manifold.



Figure 5-14

6. Use heat resistant tape to secure the nozzle wires and thermocouple wires just above or below the insulator pod. The nozzle is ready for assembly with the thermocouple fully installed.



Figure 5-15

Nozzle Insertion



NOTE

Prior to commencing assembly verify manifold and nozzle cutouts in mold plates are to specification to ensure proper clearance to hot runner. Improper clearance will affect system performance.

1. Clean the nozzle well seating bore.
2. Install the nozzle.



CAUTION

Systems with gate seals that are not accessible when fully assembled require the gate seals to be torqued hot prior to installation.

The mold plate needs to be in horizontal position when inserting nozzles. Care must be taken when handling the nozzles.

For Liner systems, damage to the tip of a nozzle can result in gate vestige. Special care must be taken with F-type, Hot Sprue and Hot Valve gating styles, where the transfer seal goes up into the part cavity. In these cases care is needed to prevent damage to the sharp edge of the gate seal and gate seal receiving bore.

3. Check that Face 1 is at the same level for all drops relative to the mold plate split line.
4. Check that nozzle sits squarely in nozzle well bore.

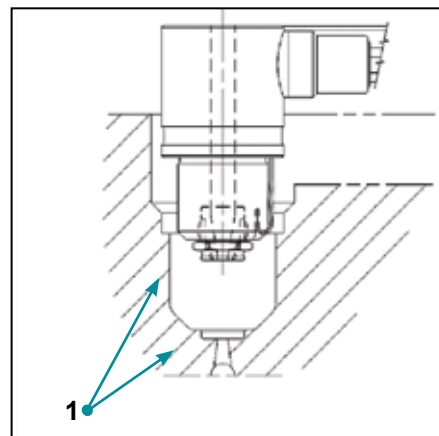


Figure 5-16 Nozzle Well Cleaning

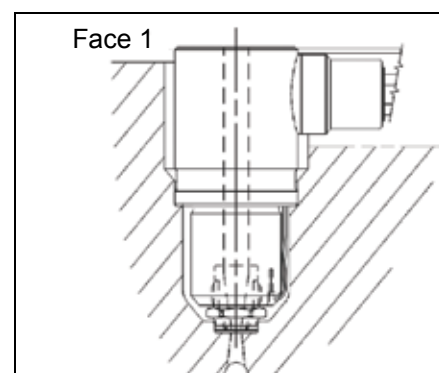


Figure 5-17

Nozzle Wire Layout

Back Mounted Thermocouples

1. Place a zone number on each wire and thermocouple.
2. Try to organize and tape wires by zone and plug.
3. Install the wires into the wire channels and secure with wire retainers.
4. Feed the wires back through the wire channel in the mold base to the electrical box. Do not cut the wires until the remaining components are installed.

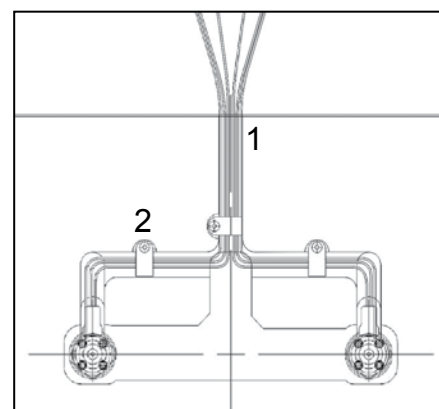


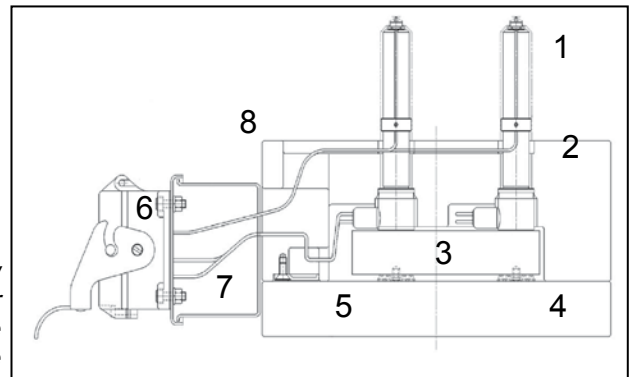
Figure 5-18 Wiring Layout
1. Wire Channel 2. Retainers

Front Mounted Thermocouples

1. Place a zone number on each wire and thermocouple.
2. Try to organize and tape wires by zone and plug.
3. Install the wires into the wire channels and secure with wire retainers.
4. Feed the wires back through the wire channel in the mold base to the mold plug. Do not cut the wires too short. Leave sufficient wire for future maintenance and ease of access.

Figure 5-19 Thermocouple Layout - Side View

1. Thermocouple 2. Wire Retainer
3. Manifold 4. Manifold Backing Plate 5. Power Wire
6. Mold Plug 7. Electrical Box 8. Manifold Plate



Valve Bushings

Types of Valve Bushings

- Heated
- Non-Heated

Valve Bushing Installation

This procedure applies to valve gated systems that are bolt-in design. Refer to the parts lists and your general assembly drawing to determine if your system has a valve bushing.

1. Mount the valve bushing on top of the nozzle.



NOTE

The valve bushing for *Accu-Valve* has a locating dowel pin with the mold.

2. Install the locating dowel. Ensure the dowel pin is not too long as this will effect the seal between the nozzle and the manifold.



NOTE

If required, attach a crane of sufficient lifting capacity to the manifold.



WARNING

Make sure the lifting eyebolt, chain and crane can support the weight of the manifold. Failure to do so may cause serious injury.



Figure 5-20 Valve Bushing Types
1. Non-Heated 2. Heated

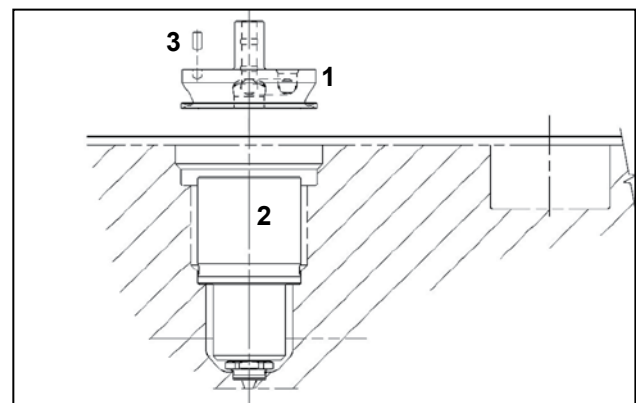


Figure 5-21 Valve Bushing
1. Valve Bushing 2. Nozzle 3. Locating Dowel

3. Apply anti-seize on the threads of each screw.
4. Lower the manifold into position.

**WARNING**

Ensure the dowels are in the correct positions.

5. Install screws through the manifold and into the manifold plate (Mounting screw thread must start at the flange seal level). Refer to the GA drawing(s) for correct screw size.
6. Torque screws to value indicated on the general assembly drawing and secure manifold to the manifold plate.

**NOTE**

On bridge manifold systems, main to sub-manifold screws should be torqued 1/3 higher than specified on general assembly drawings.

**WARNING**

Do not shorten the screw length.

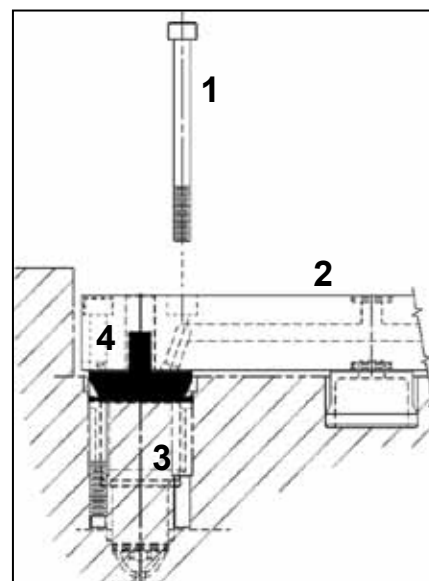


Figure 5-22 Valve Bushing Installation

1. Mounting Screw
2. Manifold
3. Nozzle
4. Valve Bushing

Mounting the Manifold

Introduction

There are three methods used to locate the manifold:

1. Manifold Locator
2. Dowel Pin Locator
3. Manifold and Slot Locator

Manifold Locator

**NOTE**

Check GA drawing for information for your system.

1. For some systems locators are supplied oversize (X) and must be ground to the same level as the top of the nozzles. Remove the material from the bottom face of the locator (FACE Y). This will allow SURFACE (A) and SURFACE (B) to be at the same level in the cold condition. **However, check the GA drawing for exception notations.**
2. Blue the manifold locator into the bore to ensure proper seating.
3. Install the locating cam dowel pin.
4. Install the locating cam onto the dowel pin.

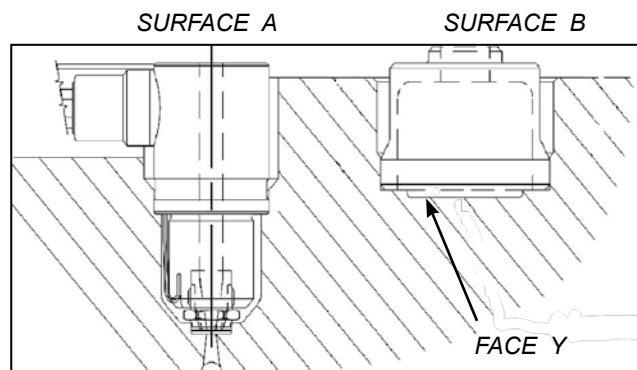


Figure 5-23 Locator Surface

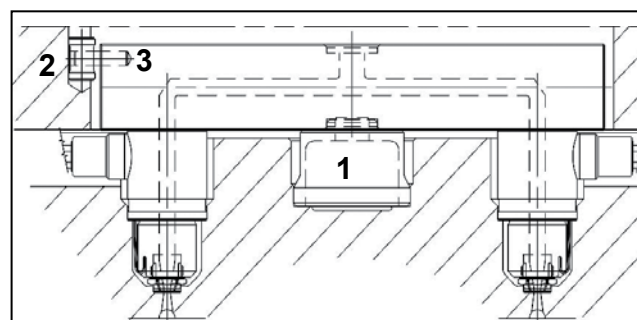


Figure 5-24 Manifold with a Locator
1. Manifold Locator 2. Locating Cam 3. Dowel Pin



WARNING

Make sure the lifting eyebolt, chain and crane can support the weight of the manifold. Failure to do so may cause serious injury.

5. If required, attach a crane of sufficient lifting capacity to the manifold.
6. Check for correct seating and height.
7. Check that there are no pinched wires.

Dowel Pin Locator

1. Install the dowel pin into the mold.
2. Check that the dowel pin does not touch the top of the manifold.
3. Install the locating cam dowel pin.
4. Install the manifold locating cam onto the dowel pin. If required, attach a crane of sufficient lifting capacity to the manifold.
5. Place the manifold on top of the nozzles and locating dowel.
6. Check for correct seating and height.
7. Check that there are no pinched wires.

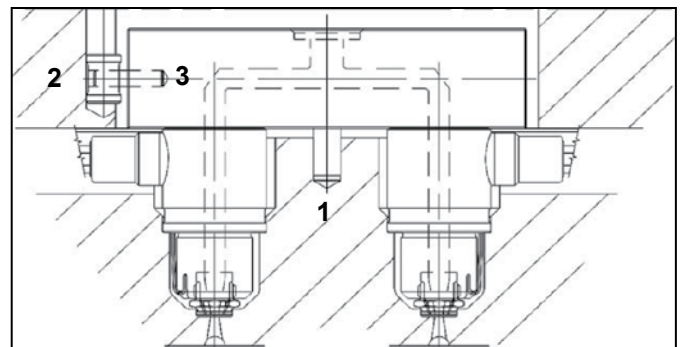


Figure 5-25 Manifold Locating with a Dowel Pin
1. Manifold Locating Dowel 2. Locating Cam 3. Dowel Pin

Manifold and Slot Locator

1. Blue the manifold locator into the bore to ensure proper seating.
2. Install the slot locator into the mold. Ensure sufficient gap between the slot locator and the manifold slot top surface. Under no circumstances should they touch.
3. Place the manifold on top of the nozzles and manifold locator.
4. If required, attach a crane of sufficient lifting capacity to the manifold.
5. Check for correct seating and height.
6. Check that there are no pinched wires.

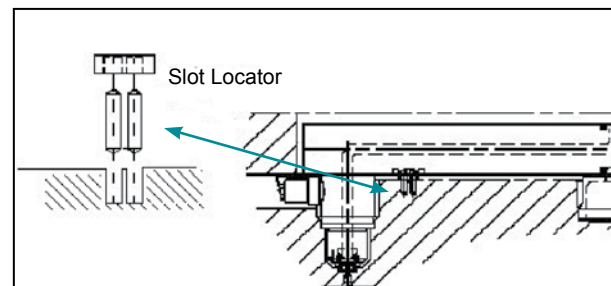


Figure 5-26 Manifold with Slot Locator

Installing the Manifold Thermocouple

This procedure only applies to integrated systems.

1. Although not necessary, a thermal compound may be applied to the thermocouple tip to ensure a good contact.
2. Insert the thermocouple into the bore. Check that the thermocouple is touching the bottom of the hole.
3. Press down on the thermocouple and gently bend the thermocouple sheath through 90°.
4. Check that the thermocouple sits in the manifold cut-out.
5. Install the thermocouple washer and screw.
6. Install a zone number on each wire and thermocouple.
7. Tape wires for each zone together.
8. Install the wires into the wire channels and secure with wire retainers.
9. Feed the wires back through the wire channel in the mold base to the electrical box.

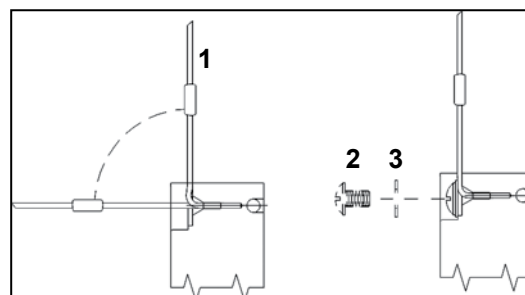


Figure 5-27 Thermocouple Installation
 1. Thermocouple 2. Screw 3. Washer
 4. Assembly

Main Manifolds

Manifolds distribute melt from the inlet component to one or more sub-manifolds. If you have a sub manifold configuration, follow these instructions. This system will have one of two configurations for inlet seals. Refer to the general assembly drawing to determine which applies.

- Inlet seal without step
- Inlet seal with step

Inlet Seal Installation (without step)

Manifolds that use a seal without a step:

1. Place the inlet seal into all sub-manifold inlets.
2. Check that the inlet seal orientation is chamfer down.
3. Check that all inlet seal heights are at the same level.
4. Install the manifold locators. Refer to "*Mounting the Manifold*".
5. Check that all components are free of debris.

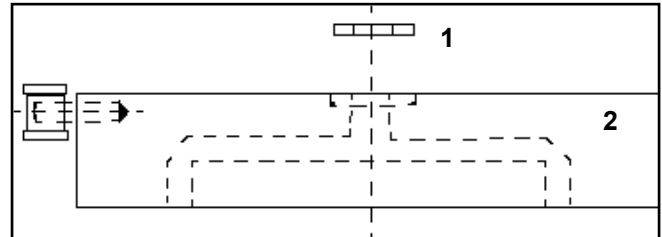


Figure 5-28 Inlet Seal without Step
1. Inlet Seal 2. Sub-Manifold

Inlet Seal Installation (with step)

Manifolds that use inlet seals with a step:

1. Install the step inlet seal to the manifold.
2. Install the dowel pin into the seal and manifold.
3. Lower the main manifold into position.
4. Install manifold mounting screws and torque to required settings.
5. Refer to your general assembly drawing for specifications.
6. Install the manifold thermocouples. Refer to "*Installing the Manifold Thermocouple*".

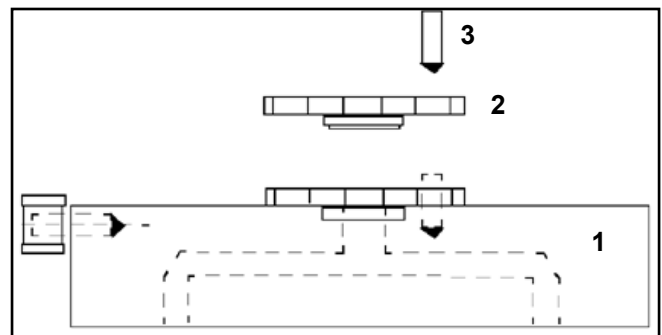


Figure 5-29 Inlet Seal with Step
1. Sub-Manifold 2. Inlet Seal 3. Locating Dowel



NOTE

On bridge manifold systems, mounting screws should be torqued 1/3 higher than specified on general assembly drawings.

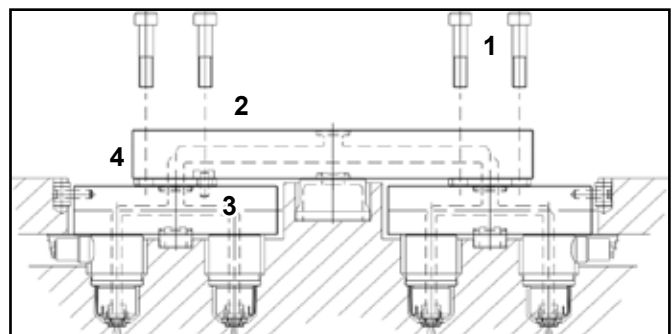


Figure 5-30 Install Main Manifold
1. Mounting Screws 2. Main Manifold
3. Dowel Pin 4. Inlet Seal

Installing the Pressure Disk / Valve Disk

Review your parts list and general assembly drawing to determine the feature installed in your system.

- Pressure Disk - is compressed by thermal expansive forces to form part of the plastic sealing mechanism. Also helps to reduce thermal transfer to a minimum.
- Valve Disk - is compressed by thermal expansive forces to form part of the plastic sealing mechanism. It's high tolerance bore allows the valve pin to shift through it without plastic leakage and part of it enters the melt stream and helps guide the plastic flow without stagnation.

For additional information please refer to "Establishing Your System Type".

Pressure disks and valve disks are supplied oversize in height and require grinding to dimensions specified on the general assembly drawing.

$$\text{Pressure disk or valve disk height} = \text{Pocket depth} - (\text{Manifold thickness} + \text{Nozzle flange} + \text{Air gap})$$

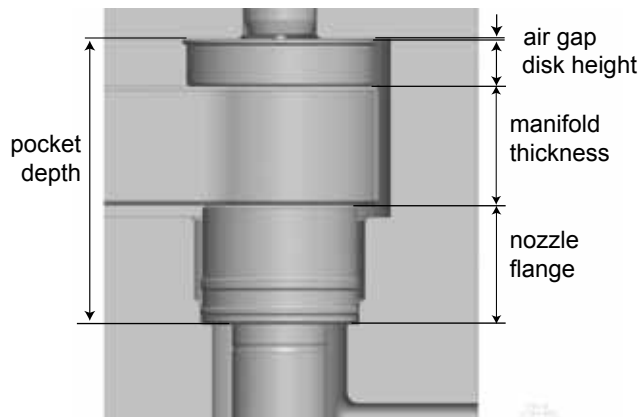


Figure 5-31 Calculating
Pressure Disk / Valve Disk Height

Pressure Disk

1. Install the manifold to the nozzle.
2. Refer to the general assembly drawing for pressure disk dimensions before calculating the pressure valve disk height.
3. Pressure disks are supplied oversize in height, grind equal amounts from each side to give 0.00 to 0.025mm cold clearance and retain maximum strength of the 'V' form. Some systems require a larger air gap, refer to the general assembly drawing.

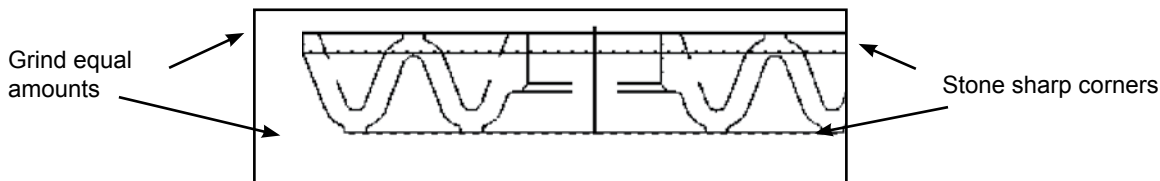


Figure 5-32 Pressure Disk

4. Remove the sharp corners after grinding.
5. Install the pressure disk spring dowel to the manifold.
6. Install the pressure disk to the manifold.

Valve Disk

Valve disks are supplied oversize in height and require grinding to dimensions specified on the general assembly drawing before calculating the pressure valve disk height.

1. Grind the valve disk on top side only.
2. Remove sharp corners after grinding and clean the valve disk, especially inside the valve pin bore.
3. Install the manifold to the nozzle.
4. Install the valve disk. Check that the arrow engraved on the valve disk corresponds to the direction of the melt flow. Ensure correct air gap between the valve disk and the top plate, as specified in the GA drawing.
5. For information on removal, refer to Valve Disk Removal, within the Maintenance Procedures section.

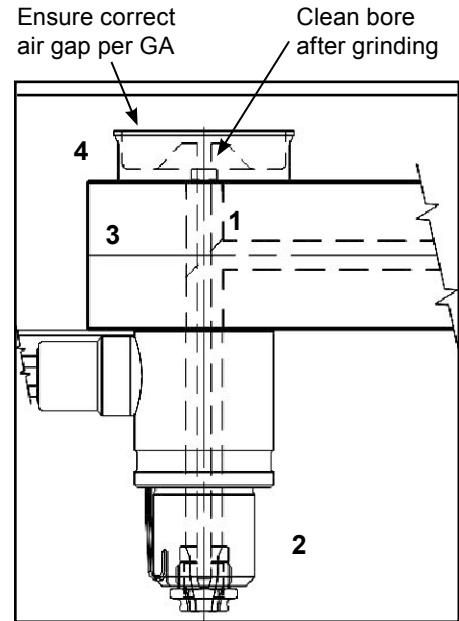


Figure 5-33 Manifold to Nozzle Mounting
1. Spring Dowel 2. Nozzle 3. Manifold
4. Pressure Disk

Alternate Method - Air gap adjustment from top clamp or hydraulic plate

1. Calculate and machine the nozzle bore seat with additional air gap value. (Example: Flange height + Manifold height + Pressure or valve disk height + Air gap value)
2. Install the nozzle into the manifold plate.
3. Install the manifold to the nozzle.
4. Refer to the general assembly drawing for pressure / valve disk locations.
5. Measure the gap between the top of the manifold plate and the top of the pressure / valve disk. Ensure that it matches the air gap value on the general assembly drawing.

Installing Heater Plates

These procedures apply to systems with external heater plates. Refer to the general assembly drawing to determine which heater plate applies to your system.



NOTE

Current bronze heater plates are directly interchangeable with previous copper or aluminum based plates that may exist on your *Mold-Masters* system. However, when multiple heater plates are controlled by one thermocouple, these heater plates must be made of the same material, of equal voltage and are located in similar thermal environments.



CAUTION

Heater plates are controlled by a thermocouple located in the heater plate. Do not control the heater plate from a thermocouple in the manifold.

1. Insert the thermocouple into the bore. Ensure the thermocouple is touching the bottom of the bore hole.
2. Press down on the thermocouple and gently bend to 90°.
3. Install the heater plate to the manifold. Refer to the general assembly drawing for location.

CAUTION



This is a pinch point area. Use caution when installing the heater plate to the manifold plate. Failure to do so could result in damage to the thermocouple.

4. Secure the heater plate to the manifold. Use anti-seize on threads.



CAUTION

Do not over-tighten the mounting screws. This could result in the heater plate losing contact with the manifold plate. Refer to the general assembly drawing for the correct torques. It is recommended that the heater plate wires be isolated and grouped so that they do not have to be disconnected if the manifold needs to be dismantled for repair.

5. The heater plates are supplied with the power wires connected. Place a zone number on each wire and thermocouple.

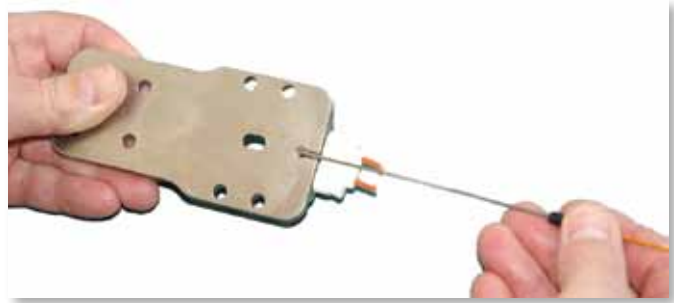


Figure 5-34 Heater Plate and Thermocouple

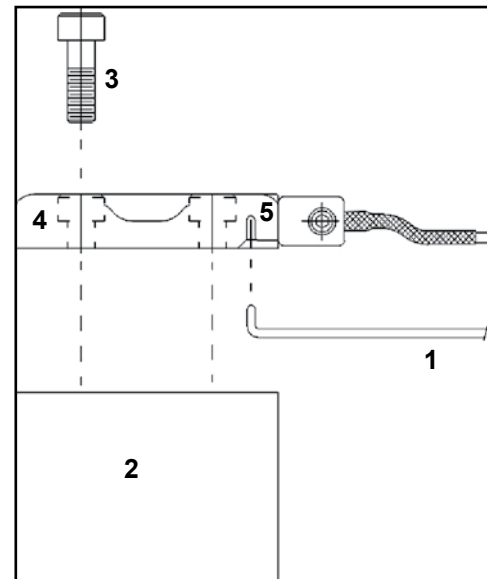


Figure 5-35 T/C Installation
1. Thermocouple 2. Manifold
3. Mounting Screw 4. Heater Plate
5. Thermocouple Bore Hole Plate

6. Tape wires for each zone together.
7. Install the wires into the wire channels and secure with wire retainers.
8. Feed the wires back through the wire channel in the mold base to the electrical box.

Installation of Inlet Components

The following procedures refer to different system configurations. Refer to your parts list and general assembly drawings to determine your system type.



CAUTION

For all inlet components it is important that the mold locating ring is touching the inlet component just enough for sealing the area. This should be doubled checked with the system drawings.

Back Plate Installation

1. Check the machine nozzle radius.
2. Check the seating on the bottom face of the back plate and manifold.
3. Install the back plate onto the manifold.
4. Install M8 mounting screws through the back plate to the manifold using anti-seize on threads.
5. Torque screws to value indicated on the GA drawing in a cross pattern, in 5 ft/lb increments.



NOTE

The machine nozzle bore should be no smaller than 1.0mm (0.040") smaller than the back plate bore and no larger than the back plate bore.

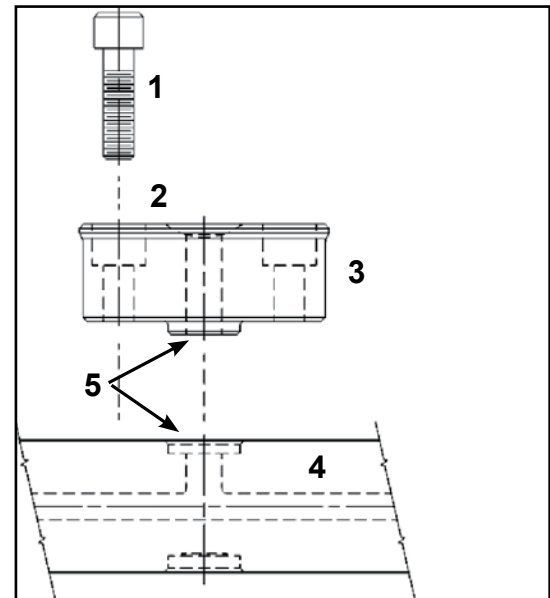


Figure 5-36 Nozzle Pad Installation
1. Mounting Screw 2. Nozzle Radius
3. Back Plate 4. Manifold 5. Bottom Face

Center Heater Installation

The center heater may require the machine nozzle radius to be added.

1. Place the center heater on the manifold.
2. Rotate the center heater to align with the tapped holes in the manifold and align terminals with cut out.
3. Install mounting screws through the center heater into the tapped holes of the manifold. Use anti-seize on the screws.
4. Torque screws to values indicated on the general assembly drawing.
5. Place zone number on each wire and thermocouple.
6. Tape wires for each zone together.
7. Install the wires into the wire channels and secure with wire retainers.
8. Feed wires back through the wire channel in the mold base to the electrical box.

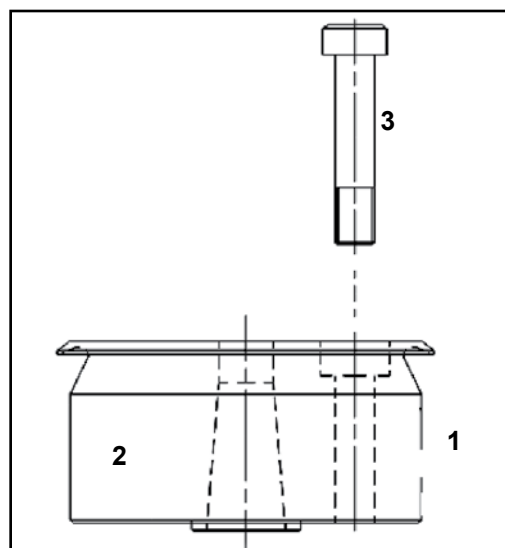


Figure 5-37 Center Heater Assembly
 1. Thermocouple 2. Center Heater 3. Screw

Three Piece Center Heater Installation

1. Install the back plate on the manifold.
2. Mount the center heater on back plate.
3. Although not necessary, a thermal compound may be applied to the thermocouple tip to ensure a good contact.
4. Install the thermocouple.
5. Install the cover plate.
6. Install M8 mounting screws through the cover plate into the tapped holes of the manifold. Use anti-seize on screws.
7. Torque screws to values indicated on the general assembly drawing.

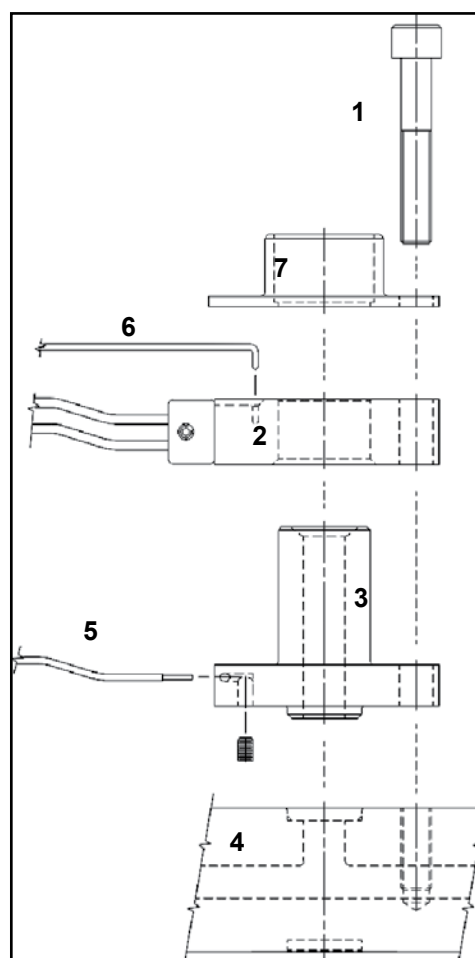


Figure 5-38 3 Piece Assembly
 1. Screw 2. Center Heater 3. Back Plate 4. Manifold 5. Ground Wire
 6. Thermocouple 7. Cover Plate

Inlet Extension Installation

1. Place the inlet extension on the manifold.
2. Install mounting screws through the nozzle flange and into the manifold.
3. Torque screws to manifold using anti-seize on threads.
4. Place a zone number on each wire and thermocouple.
5. Tape wires for each zone together.
6. Install the wires into the wire channels and secure with wire retainers. Feed the wires back through the wire channel in the mold base to the electrical box.

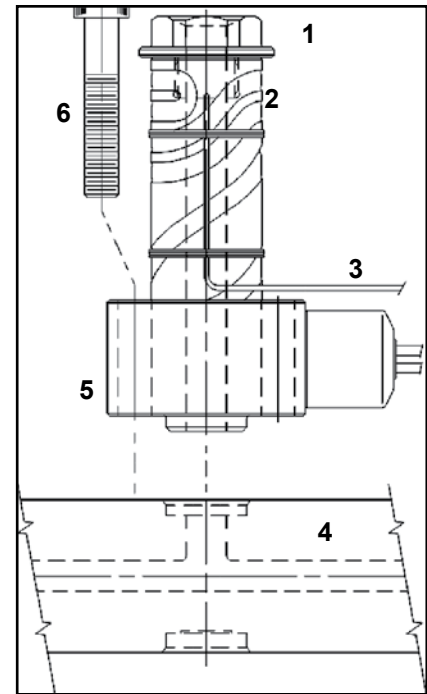


Figure 5-39 Inlet Extension
1. Extension Tip 2. Inlet Extension
3. Thermocouple
4. Manifold 5. Nozzle Flange 6. Screw

Inlet Extension with Pressure Sleeve



CAUTION

Always install the inlet extension, pressure sleeve, clamp plate and locating ring with the mold plates in the horizontal position. Failure to do so could result in damage to the components and cause material leakage.

1. Place the inlet extension on the manifold.
2. A pressure sleeve is supplied oversize in length. Refer to general assembly drawing to determine length of pressure sleeve.
3. Cut the inlet extension pressure sleeve to the required height.
4. Chamfer the outside edge of the pressure sleeve.
5. Place zone number on each wire and thermocouple.
6. Tape wires for each zone together.
7. Install the wires into the wire channels and secure with wire retainers.
8. Feed the wires back through the wire channel in the mold base to the electrical box.
9. For electrical checks, refer to the Electrical Testing section.

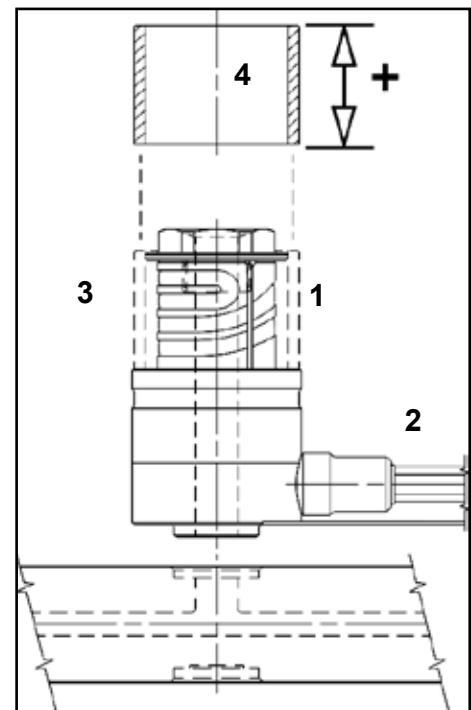


Figure 5-40 Inlet Extension with Sleeve
1. Inlet Extension 2. Manifold
3. Extension Tip 4. Pressure Sleeve

Section 6 - Electrical Testing

Introduction

This section contains electrical test procedures for your *Mold-Masters* hot runner system.



WARNING

To avoid serious burns wear safety clothing consisting of a protective heat-resistant coat, heat-resistant gloves and a full face shield over safety glasses. Use adequate ventilation for fumes.

Contact with heated components may cause serious burns. Use a sign in a visible location indicating "Danger: Do Not Touch".

Before performing any electrical work. Check that the hot runner is suitably grounded. off the temperature controller and disconnect all electrical wires leading from the mold. Failure to do so could result in a serious injury or death.

Wiring Check



NOTE

Ensure that a qualified electrician performs all wiring.

1. Check that each wire and thermocouple has a zone number.
2. Check that wires are organized and taped together by zone and plug.
3. Check all wires are secured in wire channels.
4. Connect all power leads and thermocouple wires to mold plugs.
5. The electricity mains should only be connected to the injection mold when all electrical connections are grounded and the mold is closed.



WARNING

A disassembled nozzle should only be connected to an electrical supply when the nozzle has been grounded or a safety isolating transformer is used.

Ground Shorts Test

1. Use an ohm meter to check for continuity between the Mold Power Connector ground pin (metal tabs on side) and the manifold steel. The ohm reading should be zero.
2. Measure the resistance between each pin of the Mold Power Connector (See Figure 6-1) and ground (mold base). The reading should be ∞ (infinity). Occasionally, the electric heaters accumulate moisture, which can reduce the resistance value to between 100 K Ω to 10 M Ω . The controller should be designed to remove this moisture during start-up. Never apply full power to a heater if the insulation resistance reading is below 300 K Ω . Heater resistance above 500 K Ω is acceptable. Also check this if the mold has not been in use for a number of weeks/months.
3. If necessary, remove excess moisture before placing the heater under full current.

Thermocouple Continuity Test

1. Measure the resistance between each pair of thermocouple wires on the mold's Thermocouple Connector. (See Figure 6-1). The resistance should be between 2.5 Ω and 25 Ω .
2. To verify alignment of thermocouple to heater, turn ON one zone at a time and check that the temperature responds accordingly when the set temperature is adjusted.

Pinch Point Test

1. If there is a suspected pinch point on the thermocouple, remove the thermocouple from the hot runner.
2. Connect a controller to read the temperature.
3. Immerse the sheath of the thermocouple in boiling water at the point that the thermocouple reads the temperature.
4. A good thermocouple will show a temperature rise as soon as the tip of the thermocouple is immersed in water. If there is a pinch point in the thermocouple there will be no change in the reading until the pinch point on the thermocouple is immersed in water.



Figure 6-1 Mold Plug
1. Mold Power Connector
2. Thermocouple Connector

Heater Continuity

Measure the resistance between each pair of heater power wires at the mold power connector.

Compare your reading with your general assembly drawing.

Where:

R = resistance V = voltage P = power
$$R = \frac{V^2}{P}$$

Thermocouple Wiring Guidelines

- Effective June 2010, *Mold-Masters* thermocouples are Type "J" ungrounded. Prior to this date *Mold-Masters* thermocouples are type "J" grounded.
- Thermocouples are color coded to ASA standards. (White "+" / Red "-").
- The tip must not be cut or crimped, and must touch the bottom of the bore in order to measure the correct temperature.
- Each heat source should have its own closed loop temperature control in order to achieve accurate control.
- If there are not enough control zones, heat sources that have the same wattage and affect the same environment, may be grouped together.



CAUTION

Exceeding controller zone amperage will cause controller fuses to blow.

Heating Test with a Temperature Controller

- Never start the heating with more than 40% of power.
- Stay a minimum of 5 minutes at 212°F (100°C) before increasing heat.
- Stay with the system and monitor the initial heating to minimize risk.

Section 7 - Hot Half Assembly

Introduction

The following section is a step-by-step guide to assembling your *Mold-Masters* hot runner system.

Assembling the Hot Half

1. Check that the nozzle well depth (L) in the cavity plate is to *Mold-Masters* specifications. See Figure 7-1.

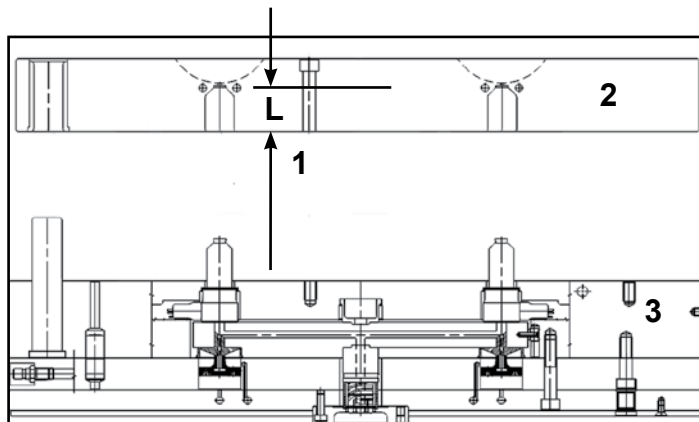


Figure 7-1 Nozzle Depth
1. Nozzle Well Depth (L) 2. Cavity Plate
3. Manifold Plate



NOTE

For valved systems, the hot half is provided with valve pins already installed. Refer to the general assembly drawings for instructions. For valve assembly details refer to the Valve Actuator Section.



WARNING

Make sure the lifting eyebolt, lifting chain and crane are rated to adequately support the weight of the plate(s). Failure to do so can cause a serious injury. Do not assemble/disassemble cavity plate with the valve pins forward. Valve pins must be retracted prior to cavity plate installation.



CAUTION

Potential pinch point. Ensure that all wires are in the retainer grooves. Failure to do so can cause lost production due to hot runner down time. For valve gated systems it is recommended to have the pins in the open position to reduce the possibility of damage.

2. Attach a crane that is rated to adequately support the weight of the cavity plate.
3. Check that all wires are in the retainer grooves.
4. Protect the gate seal before installing the cavity plate to the manifold plate.
 - 4.1 Leave the hot half in a horizontal position.
 - 4.2 Prepare the cavity plate for assembly.



CAUTION - IMPORTANT!

Heat up all manifolds to 356°F (180°C). This expands the system slightly to eliminate the cold clearance and ensures the nozzle stays straight ahead for correct alignment to the gate insert. Do not lose too much time before continuing to install the cavity plate. Damage may occur if the nozzle temperature becomes more than 100°F (55°C) hotter than the cavity plate.

5. Install the cavity plate to the manifold plate. If the plates are not assembling easily, remove the cavity plate and check for interference.
6. Install the mounting screws and torque to required specifications.
7. Attach a crane that is rated to adequately support the weight of the mold (cold half).
8. Latch the hot half to the cold half.

**WARNING**

Make sure the machine has been locked out and tagged out in accordance to the machines documented procedures. Failure to do so may lead to serious injury or death.

9. Refer to machine manufacturers documentation for procedures.
10. Install the mold into the molding machine.
11. Torque the mold mounting screws to required specifications.
12. Connect wire lines, hydraulic, pneumatic and electrical components.
13. Remove latches.

Section 8 - System Start-Up & Shut Down

Introduction

This chapter explains how to start up and shut down your hot runner system.

**NOTE**

For Melt-Disks, refer to the appropriate *TempMaster* controller operating manual.

Pre-Start-up

1. Install the mold into the molding machine.

**NOTE**

The machine nozzle bore should be no smaller than 1.0mm (0.040") smaller than the back plate bore and no larger than the back plate bore.

2. Connect all water lines and test to ensure there are no leaks and that the required flow is achieved in all water circuits.
3. Connect all hydraulic / pneumatic lines (if applicable).

**NOTE**

After the hot runner system is installed in the molding machine make sure to bleed all the air out of the hydraulic lines, if applicable. Failure to do so could result in high gate vestige.

**CAUTION**

Check that the system is heated to processing temperature before actuating the valve pins. Failure to do so could cause damage to the valve pins.

4. Connect all electrical components and check / monitor to ensure that all zones are receiving heat and all thermocouples are reacting appropriately.
5. If applicable, test the valve pin actuation, but only if the hot runner is at processing temperature (see Caution below).

Start-up

**WARNING**

Take appropriate safety precautions by assuming the system is pressurized and hot at all times. Failure to do so could result in a serious injury or death.

**NOTE**

When running thermally sensitive materials, use a thermally stable material as recommended by the material supplier for the initial start-up.

1. Turn on the machine barrel and mold cooling system.
2. Prior to start-up, ensure the:
 - Machine barrel is up to processing temperature.
 - Mold cooling is on and at cooling temperature.
3. Heat up the hot runner system to processing temperature. Wait until ALL heating zones have reached processing temperature for 5 minutes before continuing.

**WARNING**

When the mold is open never inject material through hot runner system under high pressure. Failure to do so can result in serious injury or death.

4. Start-up (for empty systems or where there is no material in the gate detail) - Extrude material through the hot runner system using 500 PSI (34.4 bar) of back pressure. The purpose is to fill the Visco-Seal at low pressure. This prevents any possibility of leakage past the nozzle seal.
5. Start-up (for systems filled with material) - Purge intended shot size twice from the barrel prior to bringing the machine barrel forward to the hot runner interface.
6. Set injection time and pressure in coordination to part size, gate size and material.

**NOTE**

For hot runner systems using heater plates, allow 10 minutes of soak time after the system reaches processing temperature.

**CAUTION**

Failure to follow the above procedure may result in leakage/damage occurring in the hot runner.

Shut Down

**NOTE**

For Melt-Disc, refer to the MZ Controller operating manual.

1. Turn off all heat to the system.
2. Leave the mold cooling system on, until the hot runner system temperature is within 100°F (55°C) of the mold temperature.

**NOTE**

Thermally sensitive materials should be purged from the hot runner system prior to shut down using a thermally stable material with a similar processing temperature. For example, a system running PVC should be initially started and subsequently shut down on LDPE.

Section 9 - Color Change

Introduction

This chapter explains how to process your hot runner system.

Color Change

In order to change from one color to another, it is necessary to remove all traces of the first color from the injection molding system. Refer to the following procedures to assist in performing the color change.

Before commencing color change, review the following warnings.



WARNING

To avoid serious burns when purging wear safety clothing consisting of a protective heat-resistant coat, heat-resistant gloves and a full face shield over safety glasses.

Use adequate ventilation for fumes.

Do not look directly into the feed throat of a hopper. Unexpected release of resin may cause serious burns. Use a mirror. Failure to do so may cause serious injury.

Never handle plastic purgings or drool until they have completely cooled. Purgings may appear solid but may still be hot and cause serious injury.

Color Change for a Hot Tip / Sprue System

1. System is up and running with one color.
2. Back off machine barrel, purge and introduce new color.
3. Increase hot runner system temperature on all zones 30-40°F (20°C) above processing temperatures.
4. Increase injection speed by using boost function on controller.
5. Run 10 - 15 shots.
6. Back off injection unit and switch off all heat on the hot runner.
7. Allow hot runner system to cool down. This pulls old material away from runner walls.
8. Turn on the hot runner system and heat to processing temperature.
9. Bring machine barrel back in.
10. Increase injection speed and (mold temperature) until color change is acceptable.
11. Continue processing while resetting hot runner system temperatures and injection speed back to normal.



WARNING

Some plastics develop gases that may be dangerous to personal health. Follow the plastics supplier's recommendations. Review their material safety data sheet. Ensure the molding area is well ventilated. Failure to do so can result in a serious injury or death.

Color Change for a Valve Gate System

1. When the system is up and running with one color, back off the injection unit, purge and introduce the new color.
2. Start molding the new color until the majority of old color has been removed from the hot runner system.
3. Back off the injection unit and switch off all heats on the hot runner system.



CAUTION

Do not activate the valve gate while purging or feeding the barrel, unless the hot runner system has reached normal processing temperature.

4. Allow the hot runner system to cool down. This pulls old material away from the runner walls and allows new and old color to mix.
5. Heat up the system and start molding.

Section 10 - Hydraulic / Pneumatic Actuators

Introduction

This section explains how to assemble and install the valve actuator for:

- 5500 Series
- 6500, 6600, and 6700 Series
- 7100 Series

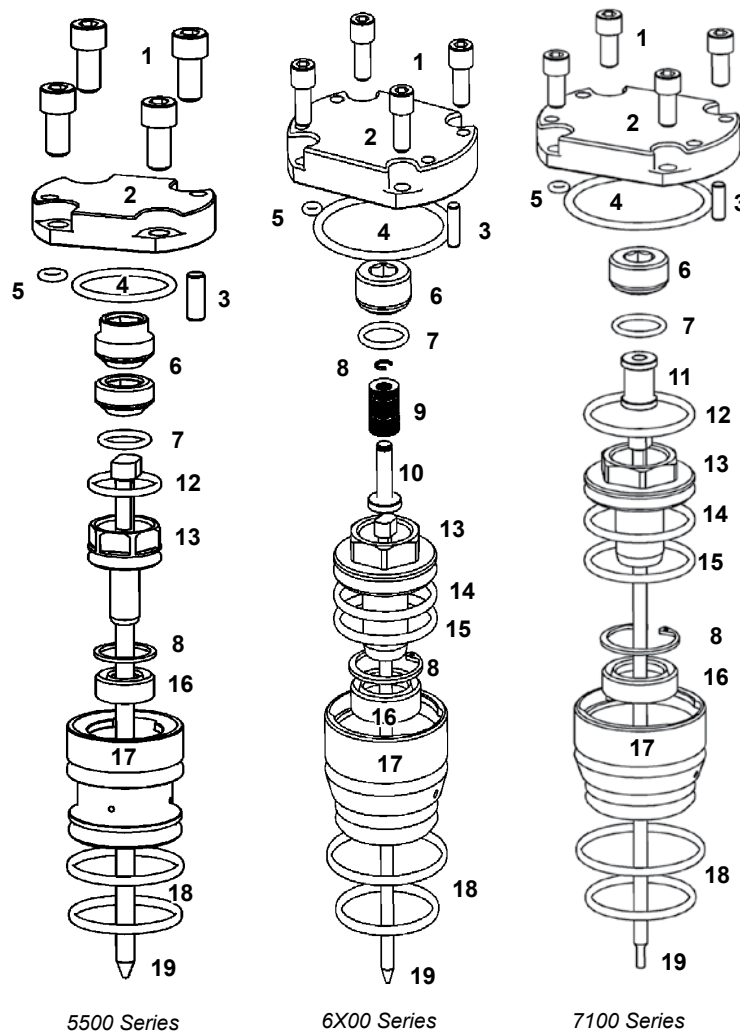
Installation and Assembly of the Valve Actuator

The following procedure explains how to assemble and install the valve actuator on a bench.



NOTE

These procedures require certain parts to be lubricated or greased.



Valve Actuator Components

1. Screw
2. Cylinder Top
3. Locating Dowel
4. Cylinder Top O-Rings
5. Small O-Ring
6. Piston Top
7. O-Ring
8. Circlip
9. HY6X00 Spring Assembly
10. HY6X00 Stud
11. HY7100 Spacer
12. Outer Seal
13. Piston
14. Inner Viton O-Ring
15. Outer Viton O-Ring
16. Rod Seal
17. Cylinder
18. Cylinder Bottom O-Rings
19. Valve Pin

Figure 10-1

Pre-Installation

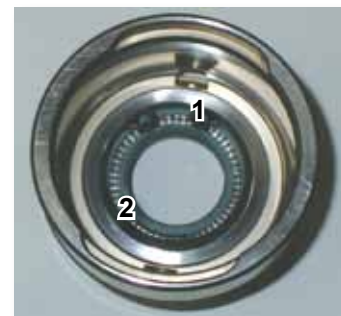
1. Prior to installing the actuator unit, check that all fluid lines in the mold plate are de-burred and do not have any metal chips.
2. Remove all rust inhibitor from the exterior of each part, prior to installation.
3. Use denatured alcohol to remove the rust inhibitor compound from each part. Do not clean the interior of the cylinder.

Cylinder Bottom Assembly

1. Insert the rod seal support disk into the cylinder (6X00 and 7100 only).
2. Press the rod seal into position.
3. Install the circlip with sharp edges facing up.
4. Lubricate the bottom cylinder external O-rings and install.



Figure 10-3 6X00 and 7100
Bottom Cylinder O-Rings



Bottom Cylinder
1. Circlip 2. Rod Seal



Figure 10-4 Seal Kit PS0003
1. Back Up Ring 2. Inner Viton O-Ring 3. Outer Seal

Piston Assembly

5500 Only

1. Lightly use silicone grease and install the O-ring on the piston.

6X00 and 7100 Series

1. Using silicone grease, lightly grease and install the inner Viton O-ring on the piston.
2. Install the back-up ring.
3. Install the outer seal. The seal should sit on top of the inner Viton O-ring. An installation tool is available (PS0003TOOL02) for installing the seal.
4. Once all 3 rings have been assembled, place installation tool PS0003TOOL01 over assembly as shown and allow rings to settle.

Figure 10-5 Piston
Assembly
1. Back Up Ring 2. Inner
Viton O-Ring 3. Stud



Figure 10-6 Piston
Assembly
1. Outer Seal 2. Installa-
tion Tool 3. Stud



Figure 10-7 Piston
Assembly
1. Stud 2. Installation Tool
PS0003TOOL02



Cylinder Top Assembly

On the inside face of the cylinder top:

1. Insert the locating dowel.
2. Using silicone grease, lightly grease and insert the small O-ring.
3. Using silicone grease, lightly grease and insert the large O-ring.



Figure 10-8 Typical Cylinder Top
1. Large O-Ring 2. Small O-Ring
3. Cylinder Top 4. Locating Dowel

Valve Pin Finishing of Tip

5500 Series

1. Install the cylinder (where applicable) and piston bottom, (without the pin and piston top) into the hydraulic plate.
2. Measure the distance AD and AC.



NOTE

Heat expansion difference to be removed from pin head.

3. Cut pin to calculated length "L". ($L = AD - AC + DE + 3.05 + 0.02^{**}$)
L = overall length from tip to top of pin head
* 3.05 = head of pin
** 0.02 = pressure preload
4. Grind the valve pin tip an angle of 20° per side (40° inclusive).
5. Lap the tip of the pin into the land area (steel section in the gate area). Refer to Figure 10-10 using a lapping guide bushing or valve bushing as a lapping guide. Recommended lapping paste 400 - 600 grit.

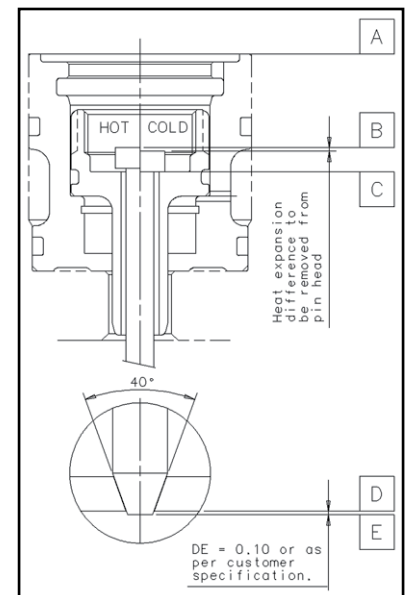


Figure 10-9 Measure Distance

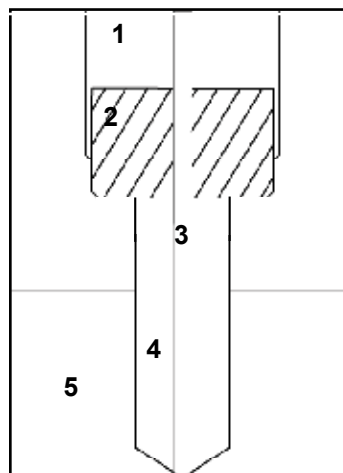


Figure 10-10a 1. Nozzle Flange Bore 2. Machined Bushing for Center Alignment
3. Tapered/Angled Valve Pin 4. Nozzle Well Bore 5. Cavity

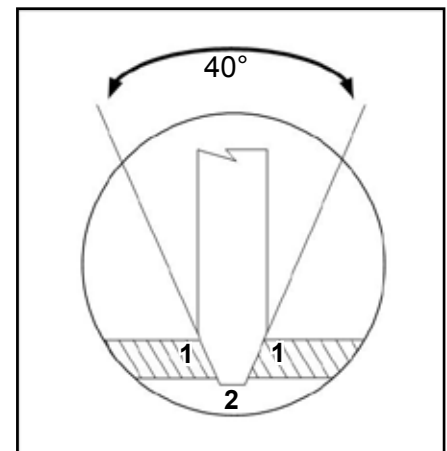


Figure 10-10b Land Location
1. Land Area 2. Cavity Face

6X00 Series

1. Calculate the heat expansion factor.
 $F_h = (\text{Processing temperature} - \text{Mold temperature}) ^\circ\text{C} \times 0.000012$.
2. Calculate the heat expansion of the valve pin.
 $HE = \text{distance BC} \times \text{heat expansion factor} = BC \times F_h$
3. Cut pin to calculated length "L". ($L = AC - 36.35 - HE + 0.3 + CD$).
4. Grind the valve pin tip to an angle of 20° per side (40° inclusive). Refer to Figure 10-7.
5. Lap the tip of the pin into the land area (steel section in the gate area) using a lapping guide bushing or valve-bushing as a lapping guide. Recommended lapping paste 400 - 600 grit.

7100 Series

1. Install the cylinder (where applicable) and piston bottom, (without the pin and piston top) into the hydraulic plate.
2. Measure the distance AC and BC.
3. Calculate the heat expansion factor.
 $F_h = (\text{Processing temperature} - \text{Mold temperature}) ^\circ\text{C} \times 0.000012$.
4. Calculate the heat expansion of the valve pin.
 $HE = \text{distance BC} \times \text{heat expansion factor} = BC \times F_h$
5. Cut pin to calculated length "L". ($L = AC - 36.35 - HE + CD$)
6. Grind the valve pin tip to fit the cylindrical gate. (Refer to the system gate detail.)
7. Assemble the hydraulic unit.
8. Heat the hot runner system to processing temperature.
9. Soak the pin in the hot runner system for 10 minutes to achieve the maximum heat expansion of the pin at the processing temperature. (Mold cooling should be running).
10. Measure the distance CD in the heated condition. Check that the head of the pin is seated.
11. Calculate the dimension to be ground (L2). $L2 = CD (\text{measurement}) - CD (\text{specified})$.
12. Grind the pin end to remove L2 (finish cut).



NOTE

When the gate vestige is critical, it is recommended to mold sample parts and measure samples to adjust the final pin length.

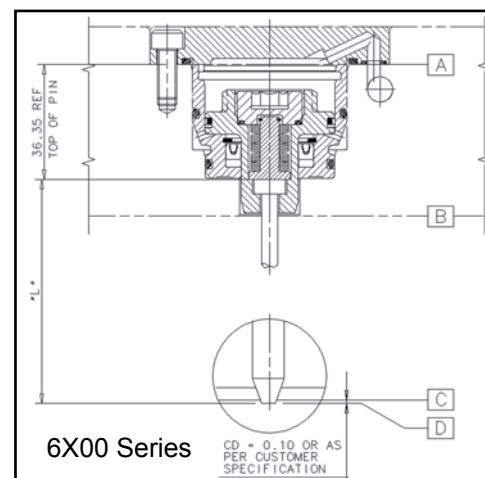


Figure 10-11 Measure Distance

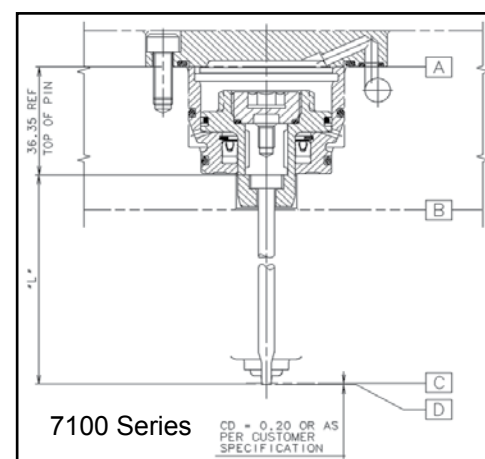


Figure 10-12 Measure Distance

Steel quality in the gating area must have:

- High grade of toughness (H13, 1.2344)
- Hardness of HRc, 46-48
- No nitration
- No chrome plating

The bottom of the nozzle well in the gate area must be free of stress caused by:

- Rough EDM
- Rough machining
- Sharp corners (JIG grinding is recommended)

Valve Pin Lapping Procedure for Tapered Valve Pins

5500 and 6X00 Series

If the shut off between the valve pin and gate area is not satisfactory, lapping of the valve pin into the gate will be required. A support bushing that fits into the nozzle flange area should be manufactured with the pin diameter in the center of the support bushing to properly align the pin with the gate area (see below). Or use the nozzle well diameter of the cavity for the support bushing as a lapping guide.

1. Install the machined bushing with the center hole matching the pin diameter.
2. Insert the valve pin through the bushing.
3. Add 400 grit lapping paste to the tapered area of the pin and lapp into the gate. Verify the shut-off with bluing compound.
4. Be sure to remove all lapping paste from the valve pin and cavity, before continuing with actuator assembly.

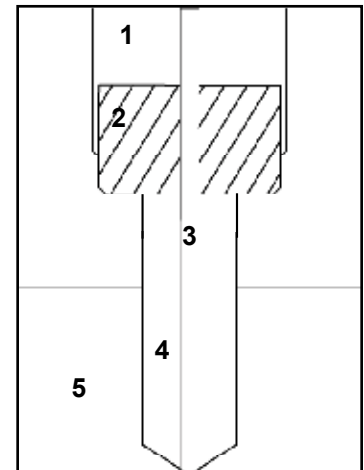


Figure 10-13 Bushing for Pin Lapping
1. Nozzle Flange Bore 2. Machined Bushing for Center Alignment
3. Tapered/Angled Valve Pin 4. Nozzle Well Bore 5. Cavity



NOTE

Do not permit the lapping paste to enter the valve bushing bore.



WARNING

Avoid skin contact with decomposing O-rings. Use appropriate protective clothing. Failure to do so can cause serious injury.



NOTE

The Viton O-rings used for the valve actuators are rated for operation below 200°C (400°F). Always turn ON the plate cooling prior to heating the hot runner system. Refer to the warning if O-rings have been subjected to higher than rated temperatures.

Valve Pin Finishing of Head

5500 Series

1. Heat the hot runner system to the processing temperature.
2. Allow the pin to soak in the hot runner system for 10 minutes to achieve the maximum heat expansion of the pin at processing temperature. (Mold cooling must be running).



WARNING

Extreme heat. Avoid contact with heated surfaces. Use appropriate protective clothing. Failure to do so can cause serious injury.

3. Measure the distance AB in heated condition.



NOTE

Heat expansion difference to be removed from pin head.

4. Check that the tip of the pin is fitted correctly into the land.
5. The heat expansion difference between the mold and hot runner is removed by grinding the back of the pinhead.
6. $HED = AC - (AB + 3.05 + 0.02 \text{ preload})$

HED = heat expansion difference

* 3.05 = head of pin

** 0.02 = pressure preload

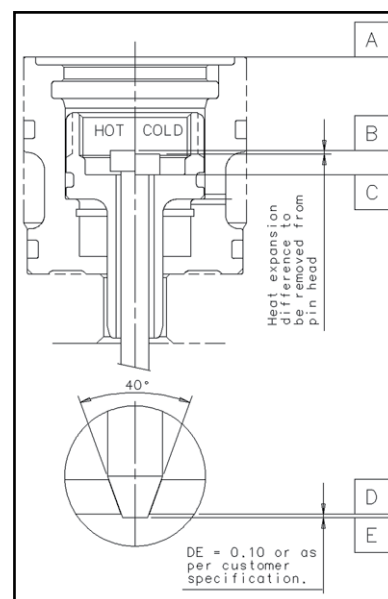


Figure 10-14 Measure Distance

7. Continue to re-assemble the actuator assembly. The maximum pin preload in the land under full heat expansion must not exceed 0.02mm.



NOTE

The standard stroke of the HY550* A/E is 4.0mm. This can be increased to maximum of 8.0mm by removing material from the piston top.

The stroke of the HY550* C/F is 8.0mm and cannot be altered.

Valve Pin Assembly

5500 Series

1. Check the valve pin length. Refer to:
"Valve Pin Finishing of Tip",
"Valve Pin Finishing of Head".
2. Slide the valve pin into the piston.
3. Grease and install the O-ring.
4. Install the piston top and tighten, torque setting 15-20 ft -lbs (20-27 Nm).

6X00 Series

1. Check the valve pin length. Refer to Valve Pin Finishing of Tip.
2. Slide the valve pin into position.



CAUTION

Failure to install the disk springs in the correct order will cause damage to the gate.

3. Assemble the disk springs to the spring retainer stud.
 - a. Check for the correct orientation of the disk springs when installing.
 - b. HY6500 series: Align the springs in 5 alternating groups of 5, convex and concave.
 - c. HY6600 and 6700 series: Align the springs in 8 alternating groups of 6, convex and concave.
4. Install the disk spring assembly on top of the valve pin.
5. Grease and install the O-ring.
6. Install piston top and tighten, recommended torque setting 15-20 ft-lbs (20-27 Nm).

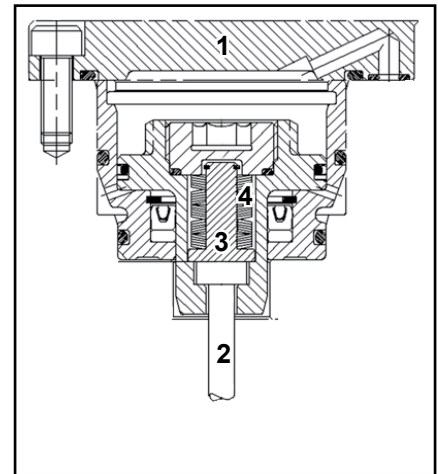


Figure 10-15 8 X 5 Disk Spring Assembly
1. Cylinder Top 2. Valve Pin
3. Spring Retainer Stud 4. Disk Springs

7100 Series

1. Check the valve pin length.
2. Slide the valve pin into the piston.
3. Install the actuator spacer with the threaded side facing towards the piston top.



NOTE

The threaded side is used for removal or installation use. By installing a screw into the spacer's threaded end it allows for simple extraction of the spacer.

4. Grease and install the O-ring.
5. Install piston top and tighten, recommended torque setting 15-20 ft-lbs. (20-27 Nm).



Figure 10-16 Piston Spacer Installation
1. Threaded Side 2. O-Ring
3. Spacer Installed (Threads Up)
4. Piston 5. Piston Top

Installing the Valve Actuator to the Hydraulic Plate

The following procedure is for new systems.

1. Lubricate the sides of the actuator cylinder, before installing into the hydraulic plate.



CAUTION

Check for sharp edges before installing the cylinder. Failure to do so could damage O-rings.

2. Tap the cylinder into the bore of the actuator plate with a nylon mallet.
3. Position the piston installation tool (PS0003TOOL01) on top of the cylinder.
4. Install the valve pin and piston into the cylinder bottom.
5. Press the valve pin into position, using a nylon mallet to finish seating the valve pin into the assembly.



CAUTION

Heat sensitive materials should be purged with a compatible less sensitive material.

If the system is not purged material in the manifold could degrade resulting in poor quality of product.

6. Remove the installation tool.
7. Check that the cylinder top dowel and O-rings are installed.
8. Install the cylinder top.



Figure 10-17 Cylinder Installation

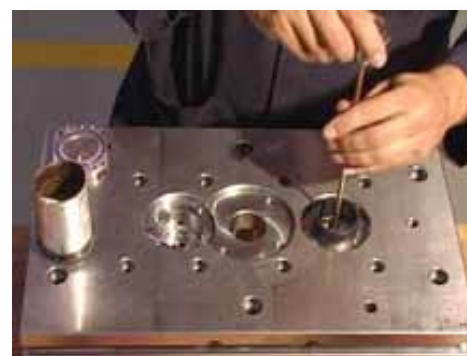


Figure 10-18 Valve Pin and Piston Installation

1. Valve Pin and Piston 2. Installation Tool



Figure 10-19 Cylinder Top

1. Cylinder Top 2. Mounting Screws
3. Hydraulic Plate

Maintenance Procedure

HY5500, HY6X00 and HY7100 Series

Actuator units should be inspected every 12 months or per pre-determined maintenance schedule. The following procedure is performed on a bench.

For Oil Systems:

1. Remove oil from system.
2. Remove the cylinder top with tool in upright position to prevent oil from entering the system.
3. Heat up the system (required to remove the valve pin).

For Pneumatic Systems:

1. Remove the cylinder top for every zone.
2. Heat up the system (required to remove the valve pin).



WARNING

Extreme Heat. Avoid contact with heated surfaces. Use appropriate protective clothing. Failure to do so can cause serious injury. If possible keep cooling on within hot half.

Do not assemble new O-rings if the plates are still hot.
Drain the oil before removing the pin from the hydraulics.

3. Install the cylinder extraction tool to assist with the removal of the cylinder.
4. Disassemble the system.
5. Inspect components.
6. Replace O-rings.
7. O-ring replacement kit is OR550P1 for 5500 series and OR650P2 for 6X00 and 7100 series.
8. When installing the rod seal, check that the rod seal is seated to the base of the cylinder and is secured in place with the circlip.
9. To complete the assembly, refer to:
 - a. Cylinder Bottom Assembly
 - b. Piston Assembly
 - c. Cylinder Top Assembly
 - d. Figure Valve Pin Assembly
 - e. Installing the Valve Actuator to the Hydraulic Plate.



Figure 10-20 HY5500 Series
Cylinder Extraction Tool Kit

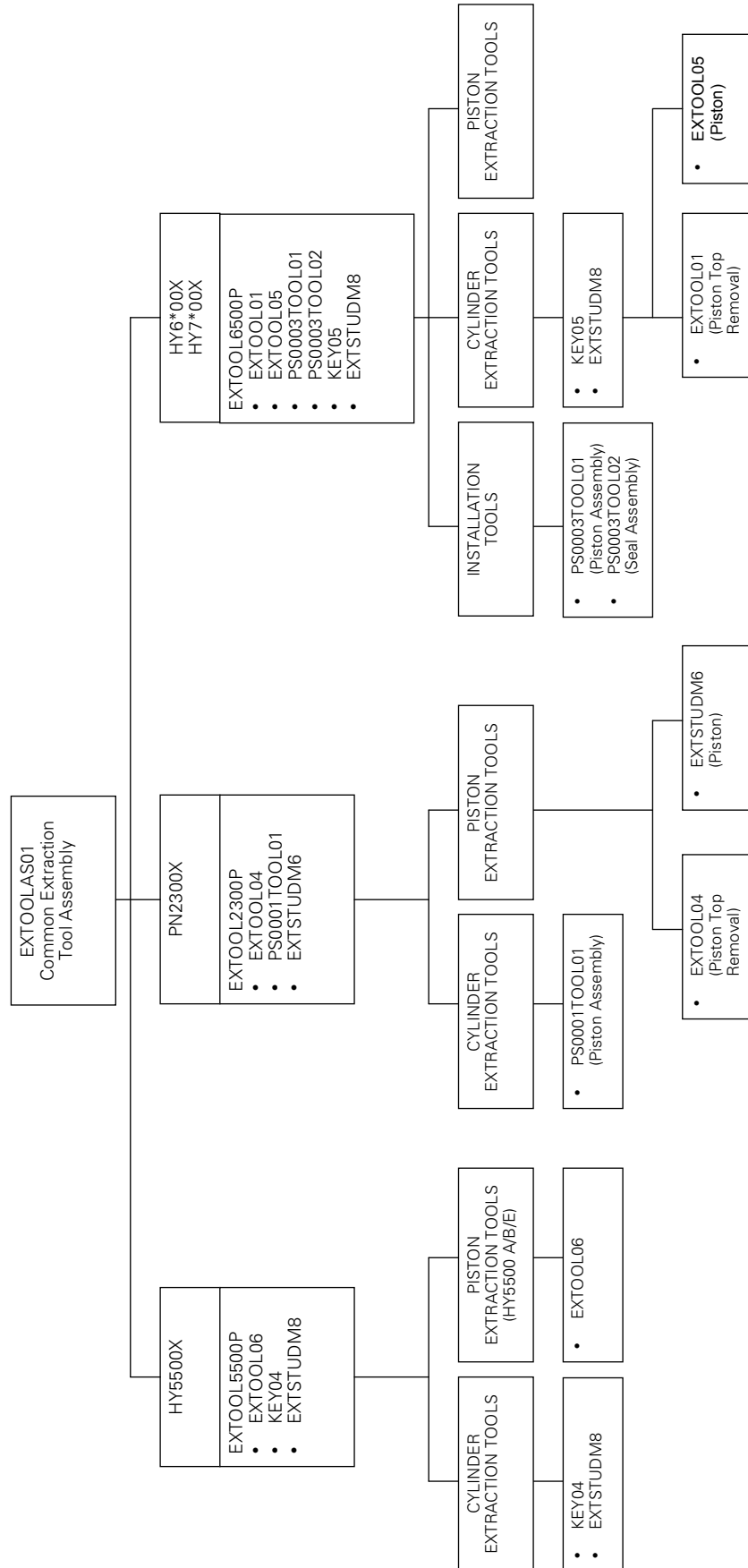


Figure 10-21 HY6/7*00 Series
Cylinder Extraction Tool Kit



Figure 10-22
Valve Disk Extraction Tool

Extraction Tool Assembly



Section 11 - Electric Actuators

Introduction

We would like to take this opportunity to thank you for purchasing a *Mold-Masters E-VG* unit.

The purpose of this manual is to assist users in the integration, operation and maintenance of *Mold-Masters* systems. This manual is designed to cover most system configurations. For additional information, please contact your representative or a *Mold-Masters* office.

Electric Valve Actuator Selection Chart

Part Name	Part Description
ES5510003A	Solenoid size 55mm stroke 3mm
LS0001A	ES5510003A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER14 & 3.0mm PIN (10" LG.) 3mm STROKE (48VDC)
LS0001B	ES5510003A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER14 & 3.0mm PIN (14" LG.) 3mm STROKE (48VDC)
LS0001x	ES5510003A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER14 w/o 3.0mm PIN 3mm STROKE (48VDC)
ES7510003A	Solenoid size 75mm stroke 3mm
LS0002A	ES7510003A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER13 & 3.0mm PIN (10" LG.) 3mm STROKE (48VDC)
LS0002B	ES7510003A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER13 & 3.0mm PIN (14" LG.) 3mm STROKE (48VDC)
LS0002x	ES7510003A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER13 w/o 3.0mm PIN 3mm STROKE (48VDC)
ES7510008A	Solenoid size 75mm stroke 8mm
LS0003A	ES7510008A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER13 & 3.0mm PIN (10" LG.) 8mm STROKE (48VDC)
LS0003B	ES7510008A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER13 & 3.0mm PIN (14" LG.) 8mm STROKE (48VDC)
LS0003x	ES7510008A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER13 w/o 3.0mm PIN 8mm STROKE (48VDC)
ES11010010A	Solenoid Size 110mm with Stroke 10mm
LS0004A	ES11010010A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER & 5.0mm PIN (10" LG.) (48VDC)
LS0004B	ES11010010A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER & 5.0mm PIN (14" LG.) (48VDC)
LS0004X	ES11010010A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/ 5mm VPHOLDER & w/o PIN
LS0005A	ES11010010A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER & 8.0mm PIN (10" LG.) (48VDC)
LS0005B	ES11010010A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/VP-HOLDER & 8.0mm PIN (14" LG.) (48VDC)
LS0005X	ES11010010A DOUBLE ACTING LINEAR SOLENOID PACKAGE w/8mm VPHOLDER & w/o PIN

ES Solenoids

ES Solenoids are precision engineered actuators with integrated permanent magnets. Inside the actuator, a moving armature is guided by linear bearings. The armature can take two end positions and is solidly held at these positions by permanent magnets. Switching between both end positions is accomplished by energising the coils.



CAUTION

Switching between both end positions of the armature must only take place by means of applying an electric current to the coils. Any switching with external mechanical means may lead to the destruction of the ES solenoid.

Safety Warnings



This product contains permanent magnets which generate a magnetic field even if the coil is not energised. This magnetic field is also effective outside of the product.

The following warnings indicate a potentially hazardous situation, which if not avoided, could result in serious injury or death.

- Magnetic fields can erase data stored on magnetic media. They can also influence or even destroy electronic and mechanic components, such as pacemakers. For this reason, the required safety distances need to be observed.
- Certain magnetic materials are toxic and/or easily soluble and therefore represent a safety hazard. Destruction and disintegration can be caused by corrosion, chemical influences, other magnetic fields, high temperatures etc. Direct contact with magnetic materials may result in allergic reactions.
- For shipping via airfreight, a dangerous goods declaration is required. Permanent magnets may not be exposed to radioactive emissions.
- During its operation, the ES solenoid may develop considerable heat. Physical contact with the solenoid during operation may result in burns.
- Loud noises can be caused during operation. Wearing hearing protection is strongly recommended.
- Activating the ES solenoid manually with external mechanical tools may lead to serious physical harm.
- When applying mechanical forces, please take into consideration that the material may break or splinter.
- Turn off a defective solenoid immediately and disconnect it from its power supply.
- The ES solenoid must be mechanically fixed before operating.
- The latest standards and regulations, such as the Low Voltage Directive need to be observed when installing the ES solenoid. In addition, any technical information printed on the label and the packaging must be observed.

Cautions



Damage to the solenoid is possible if the following cautions are not followed.

- **Any switching with external mechanical means may lead to the destruction of the ES solenoid.**
- **Oiling or greasing the moving parts of the solenoid may lead to a total failure of the ES solenoid.**
- Applying an improper voltage to the coils or exceeding the nominal switch on period may damage or thermally destroy the solenoid by overheating.
- Any mechanical damage of the surfaces may lead to corrosion.
- Exposing the unit to hard shocks during installation may interfere with the function of the ES solenoid.
- All wire leads and electrical contacts need to be protected against mechanical damages.
- Exposure to high temperatures will irreparably damage the permanent magnets.
- Prevent magnetisable particles, such as iron cuttings from getting close to the product.

- Exposing the ES solenoid to dust particles will reduce the life cycle of the bearings guiding the armature.
- Modifications of the ES solenoid may limit its function or lead to its total failure.
- The ES solenoid should be installed at a clean location.
- Only use the mounting holes provided to attach the unit.
- Use screws to mechanically attach the ES solenoid and tighten them with an appropriate torque before connecting the unit electrically.
- To apply the supply voltage, only use leads with a sufficient cross section and insulation.
- Solvents, such as Acetone or Benzine can influence the function of the ES solenoid. You may safely remove metal cuttings stuck to the solenoid by means of an adhesive tape.
- Store in a dry location at the required storage temperature.

Additional Tools Required

The following tools are required in addition to those listed in Section 4:

- Valve pin pulling tool.
- Long M5 hex key with T-handle and snap ring in tip (*Mold-Masters* item number: KEY-BPHEXTKEY5.0).
- Grease: Castrol Longtime PD2 (*Mold-Masters* item number: 104L1105I).
- Proper Valve Pin extraction tools.

Specifications

Input power: 230 V

Actuator stack height: 100mm + 35mm mounting plate

Stroke length:

- for 55mm solenoid: 3mm
- for 75mm solenoid: 3mm and 8mm
- for 110mm solenoid: 10mm

Minimum pitch:

- for 55mm solenoid: >58mm
- for 75mm solenoid: >78mm
- for 110mm solenoid: >112mm

Available gating styles: any cylindrical valve gate

Number of cavities: 2-8

Resins: commodity resins, ABS, PA

Maximum valve pin diameter:

- for 55mm solenoid: 3.2mm
- for 75mm solenoid:
 - with 3mm stroke: 5.2mm
 - with 8mm stroke: 3.2mm
- for 110mm solenoid: 8.2mm

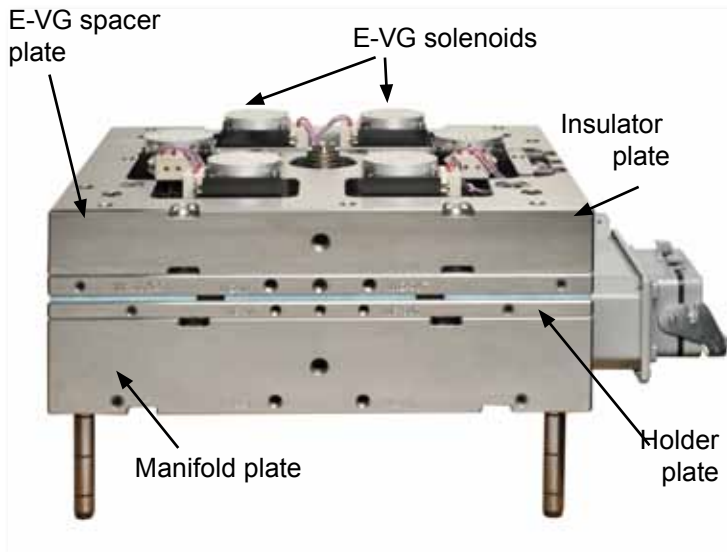


Figure 11-1 Example: 6 Cavity hot half with E-VG units.
Stack for high mold temperature >122°F (50°C)



Figure 11-2 Example: 2 Cavity Accu-Valve CX hot half and 75 mm and 55 mm EVG.
Stack for low mold temperature <122°F (50°C)



Figure 11-3 75 mm E-VG with VP Holder14



Figure 11-4 55 mm E-VG with VP Holder13



Figure 11-5 E-VG with Valve Pin Assembled

Pin Height Adjustment

The following procedure is for adjusting the pin height. The pin height can be adjusted +/- 1 mm in each direction (forward or back).



IMPORTANT

Pin height adjustments need to be done when the system is hot in order for the pin to be a true length in operating conditions. Failure to do so could result in damage to the gate.



CAUTION

Water circulating in the holder space plate should be 25°C or below.

1. Open the lock nut using the supplied lock nut tool.
2. Use the M5 hex key (KEY-BPHEXTKEY5) to turn the adjusting screw clockwise (to move the pin forward) or counter-clockwise (to move the pin back).
3. When the pin is in the correct position hold the screw with the hex key and tighten the lock nut.

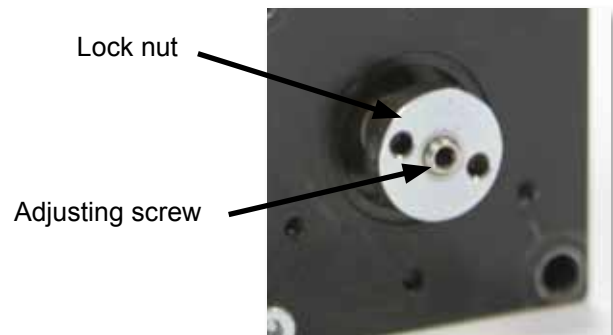


Figure 11-6 E-VG Lock Nut and Adjusting Screw

Pin Removal from 110 mm E-VG (VPHolder15/16)

1. Remove the E-VG unit.
2. Slide the pin from the T-slot.

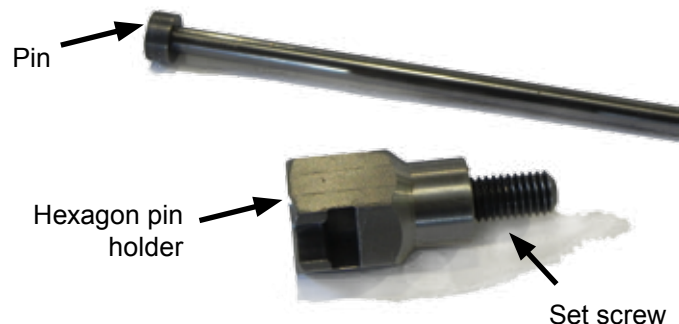


Figure 11-7 Pin Removal

Pin Installation into 110 mm E-VG (VPHolder15/16)

1. Apply high strength thread locking compound to the pin holder set screw and install it into the pin holder.
2. Apply high strength thread locking compound to the other end of the set screw and install the valve pin holder into the E-VG unit.
3. Slide the pin into the pin holder T-slot.

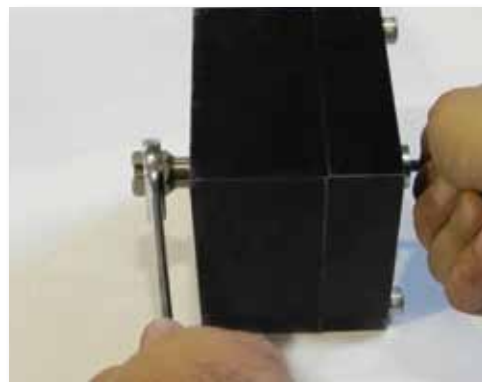


Figure 11-8a Valve Pin Holder Assembled into E-VG



Figure 11-8b Pin in Pin Holder T-Slot

Pin Removal from 75 mm E-VG (VPHolder13)

1. Remove the E-VG unit.
2. Loosen the hexagon pin holder.
3. Anchor the unit in a vice and use the M5 hex key (KEY-BPHEXTKEY5) to remove the set screw.
4. Pull the set screw out.
5. Remove the dowel pin.
6. Pull the pin out.

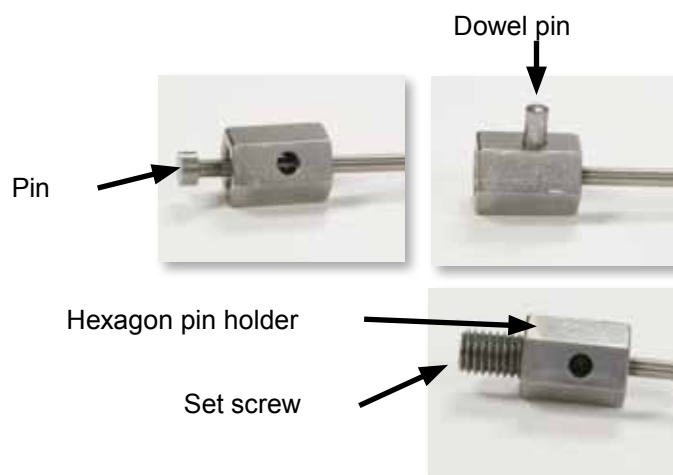


Figure 11-9 Pin Removal

Pin Installation into 75 mm E-VG (VPHolder13)

1. Place the pin in the pin holder.
2. Apply high strength thread locking compound to the dowel pin and insert it into the pin holder.
3. Apply high strength thread locking compound to the set screw and tighten set screw into the pin holder.
4. Screw the set screw back into the E-VG unit.



Figure 11-10 Valve Pin Holder 13
Assembled into E-VG

Pin Removal 55 mm E-VG (VPHolder14)

1. Remove the E-VG unit.
1. Unthread the hexagon valve pin holder from the EVG.
2. Use pliers to remove the holder clip.
3. Remove the pin.

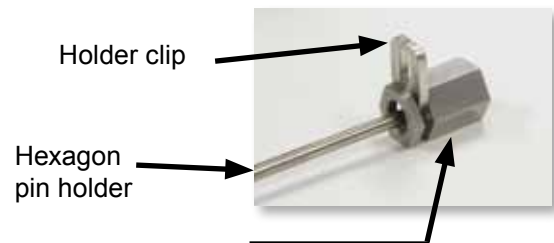


Figure 11-11 Pin Removal /
Installation

Pin Installation 55 mm E-VG (VPHolder14)

1. Place the pin in the pin holder.
2. Install the clip to hold the pin in place.
3. Apply high strength thread locking compound to the pin holder and insert it into the E-VG unit.
4. Screw the valve pin holder onto the E-VG unit.



Figure 11-12 Valve Pin Holder 14
Assembled into E-VG

Removing E-VG Unit from Hot Half

1. Unscrew and remove the wire harness cover plate.



Figure 11-13 Removal of wire harness cover plate

2. Remove the wires from the wiring harness.



Figure 11-14 Removal of wires from wire harness

3. Loosen and remove the BLACK mounting screws.

NOTE

DO NOT remove the SILVER screws.

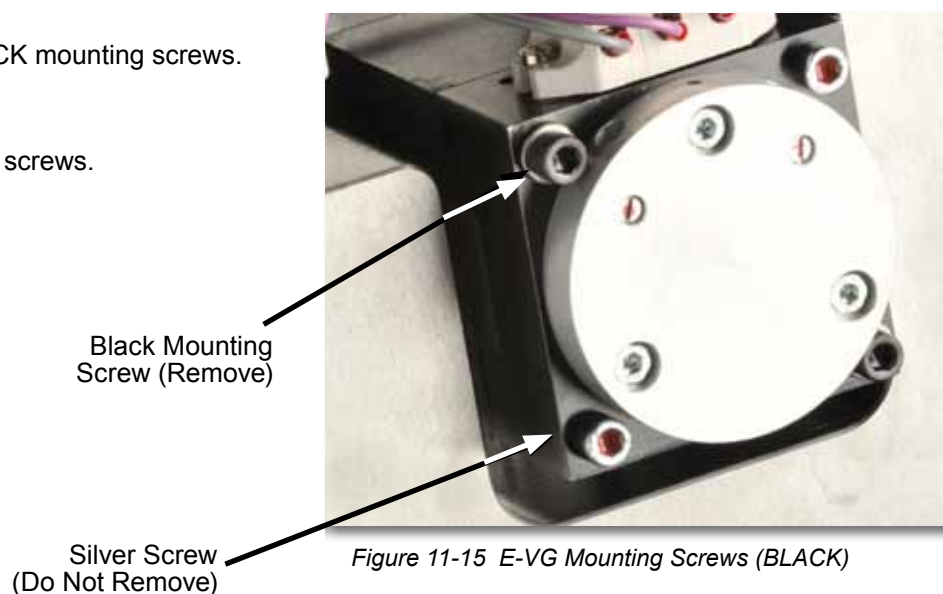


Figure 11-15 E-VG Mounting Screws (BLACK)

4. Carefully slide the E-VG unit valve pin out of the valve bushing.



Figure 11-16 Removal of unit from hot half

Installing E-VG Unit into Hot Half

1. Insert the valve pin into the valve bushing.



Figure 11-17 Insert valve pin into valve bushing

2. Insert the BLACK mounting screws.



Figure 11-18 Insert E-VG mounting screws

Installing E-VG Unit into Hot Half - con't

3. Tighten the BLACK mounting screws to the torque setting indicated on the assembly drawing.



Figure 11-19 Tighten mounting screws

4. Complete wiring per assembly drawing.



Figure 11-20 Complete wiring

5. Install wiring harness cover plate.



Figure 11-21 Install wiring cover plate

Section 12 - Maintenance Procedures

Introduction

This chapter is a guide to maintaining selective components.

Repairs that should be performed by *Mold-Masters* personnel are not included.

If you need an item repaired that is not included in this section, please call *Mold-Masters* support. The phone number and system identifier is located on the mold.

Valve Disk Removal

Some valve disks may be difficult to remove, use the following procedure to extract the valve disk from the manifold.



NOTE

Check that the manifold is secure. For "Cast in Systems" secure the manifold with clamps to prevent movement. Never heat up the system without first clamping the main manifold, especially if the nozzles are not secured with the hot half. This prevents resin from leaking between the nozzle and hot half.



Figure 12-1 Manifold Clamps



WARNING

All maintenance on *Mold-Masters* products should be performed by properly trained personnel based on local law or regulation requirements. Electrical products may not be grounded when removed from the assembled or normal operating condition. Assure proper grounding of all electrical products before performing any maintenance to avoid potential risk of electrical shock.



To avoid serious burns wear safety clothing consisting of a protective heat resistant coat and heat-resistant gloves. Use adequate ventilation for fumes. Failure to do so can result in serious injury.

1. Heat the manifold to allow any plastic still in the system to become soft.
2. Attach the valve disk extraction tool to the valve disk.
3. Attach the extraction tool to the main assembly tool. Refer to the extraction tool chart on next page.
4. Extract the valve disk.

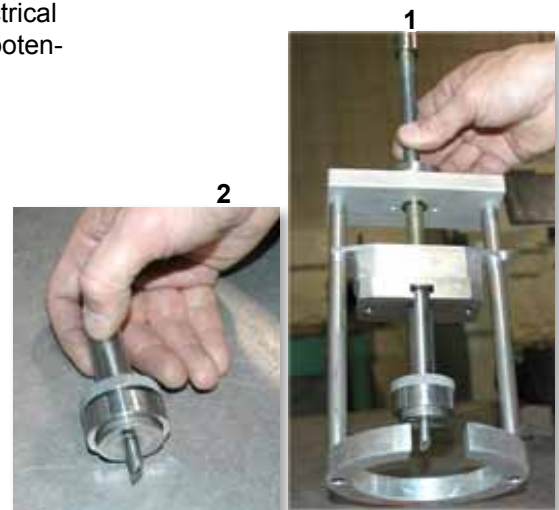


Figure 12-2 Valve Disk Extracted
1. Valve Disk Extraction Tool
2. Valve Disk

EXTRACTION TOOLS		
Part Number	Where Used	
	Valve Disk	Nozzle Type
EXTOOL07 (Ø35)	VD0035	Pico
	VD0033	Pico
	VD0085	Femto
	VD0089	Femto
	VD0102	Femto
EXTOOL08 (Ø39)	VD0013	Centi
	VD0022	Centi
	VD0069	Centi
EXTOOL12 (Ø49)	VD0034	Pico
	VD0036	Pico
	VD0037	Pico
	VD0038	Pico
	VD0027	Centi
	VD0028	Centi
	VD0031	Deci
	VD0032	Deci

EXTRACTION TOOLS		
Part Number	Where Used	
	Valve Disk	Nozzle Type
EXTOOL10P ('V' Guide)	VD0088B	Femto
	VD0094B	Femto
	VD0108B	Femto
	VD0109B	Femto
	VD0074B	Pico
	VD0110B	Pico
	VD0075B	Centi
	VD0111B	Centi
	VD0106B	Deci
EXTOOL10P1 ('V' Guide)	VD0087B	Femto
	VD0093B	Femto
	VD0065B	Pico
	VD0066B	Centi

Terminal End Removal and Installation

Although this procedure shows a nozzle terminal end, the process is the same for manifold terminal ends.

Terminal End Removal

1. If the terminal end is covered with plastic, warm the terminal end prior to removing the element sleeve.



CAUTION

Care must be taken when removing the element sleeve as not to damage the ceramic sleeve or terminal nut.

2. Grip the element sleeve at the threaded area and turn counter clockwise. If the wires rotate with the sleeve, damage may result.
3. Remove the seal.
4. Remove the set screw from the ceramic sleeve.
5. Remove the power leads.



Figure 12-3 Nozzle Terminal Assembly
1. Nozzle Flange 2. Ceramic Insert
3. Ceramic Sleeve 4. Seal 5. Element Sleeve

Terminal Installation

Although this procedure shows a manifold, the process is the same for nozzle terminal ends.



NOTE

Please contact *Mold-Masters* Spare Parts Department to ensure you have the correct repair kit and crimping tool.

Terminal Assembly

1. Assemble the repair kit components.



Figure 12-4

2. Ensure the terminal end is clean.



Figure 12-5

3. Slide the element sleeve, silicon seal and ceramic insulator onto the wires.



Figure 12-6

4. Slide crimps onto leads. Stranded wire should extend beyond the crimp.



Figure 12-7

5. Spread the wire strands and insert the lead wire onto the terminal posts.



Figure 12-8

6. Grasp the crimp with the crimping tool, slide the crimp into position over the terminal post and crimp the connection.



Figure 12-9

7. Slide the ceramic insulator and silicon seal into place.



Figure 12-10

8. Complete the repair by screwing the element sleeve into position.



CAUTION

Keep an eye on the silicon seal. It should not rotate with the sleeve or the wires may break.



Figure 12-11

Crimping Tool Chart

Product Name	Description
PUNCHHANDLE01	Ratchet Crimp, tool for attaching dies to terminal end assemblies
CRIMPDIE01	4.0mm Heater Element (Mates with CRIMPPUNCH01)
CRIMPPUNCH01	4.0mm Heater Element (Mates with CRIMPDIE01)
CRIMPDIE02	2.5 - 3.0mm Heater Element (Mates with CRIMPPUNCH02)
CRIMPPUNCH02	2.5 - 3.0mm Heater Element (Mates with CRIMPDIE02)
CRIMPDIE03	1.8 - 2.0mm Heater Element (Mates with CRIMPPUNCH03)
CRIMPPUNCH03	1.8 - 2.0mm Heater Element (Mates with CRIMPDIE03)
CRIMPREMOVEB01	Bottom Crimp Removal Insert for shearing HE crimps (Mates with CRIMPREMOVET01)
CRIMPREMOVET01	Top Crimp Removal Insert for shearing HE crimps (Mates with CRIMPREMOVEB01)



NOTE

The above tools, along with the lead wire replacement kit, are available through *Mold-Masters* Spare Parts Department at 1-(800)-387-2483.

Heater Plate Power Lead Replacement Removal

1. Remove the set screws.
2. Slide ceramic sleeve off.
3. Remove the power leads using crimp removal tool.

Installation

1. Push the replacement leads into the holes in the ceramic sleeve.
2. Crimp the leads to the terminal ends.
3. Slide ceramic sleeve over the terminal end.
4. Tighten the set screws on the ceramic sleeve to secure the terminal assembly.

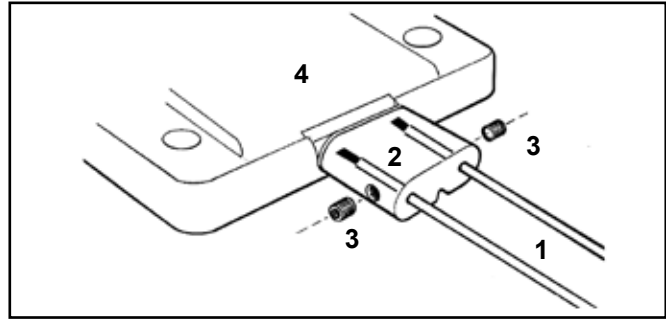


Figure 12-12 Terminal Ends Assembly

1. Power Leads 2. Ceramic Sleeve
3. Set Screws 4. Heater Plate

Gate Seal Maintenance

Reasons for Gate Seal Maintenance

- Tip damage
- Obstruction to melt flow
- Gate seal damage
- Tip wear

Multi-Cavity Systems

It is advisable to heat the system to ensure the temperature condition is met to remove the gate seals.



Figure 12-13 Gate Seals



NOTE

Use the socket supplied in the *Mold-Masters* tool kit to loosen the gate seal.

It is recommended to use a temperature controller for this procedure. If a temperature controller is not available, contact your nearest *Mold-Masters* Service Department.

For gate seal installation and torquing procedures refer to "*Gate Seal Replacement*" section.

Gate Seal Removal

The following procedure applies to all gate seals (including carbide) with threads larger than an M6 (Excluding TIT Edge).



NOTE

If the cavity plate is easily removed you can access the nozzle seals while still in the system. Hot runner systems must be within 70°F (40°C) of mold temperature before the cavity plate can be removed. It is recommended the nozzle be removed from the system before removing the gate seal.



CAUTION

Seals and liners for Accu-Valve EX & CX are a sub-assembly utilizing a manufactured interference fit. Disassembly of this sub-assembly may affect alignment of the valve pin to the gate, causing wear.



NOTE

Use the socket supplied in the *Mold-Masters* tool kit to loosen the gate seal.



Figure 12-14 Penetrating Lubricant

1. Apply penetrating lubricant to gate seal area.



WARNING

High temperature on the nozzle. Wear safety clothing such as heat-resistant coat and heat-resistant gloves. Failure to do so may cause serious injury.



CAUTION

The terminal end is a sensitive area and can easily break if not handled to specifications.

2. Leave the nozzle in the mold or remove it to a vice and clamp carefully.
3. Using the temperature controller, heat the nozzle body until all residual plastic is melted from the gate area. If the nozzle is inside the mold, heat up the whole system and turn on the cooling or remove all O-rings.
4. While the nozzle is still hot, apply a loosening pressure to the gate using the socket to remove the seal.
5. Turn off the controller and wait for 5 minutes.
6. Remove the gate seals.



Figure 12-15 Remove Gate Seal

Gate Seal Replacement

1. Clean the nozzle, especially the thread and runner.
2. Clean all residual plastic from the threads and counter bore of the gate seal.



WARNING

Ensure nozzles have cooled to room temperature. Failure to do so may cause serious injury.



CAUTION

It is critical that seal surface is perfectly clean. Failure to clean properly may result in nozzle and seal damage and leakage.

3. Check the bottom face of the nozzle counterbore for damage. If damaged, lap the bottom face of the nozzle in a circular fashion with a hardened tool and 300 grit lapping compound. If the nozzle counterbore is free of damage, proceed to step 5.
4. After lapping is complete, blue the liner to the nozzle to ensure proper mating. If the liner is making good contact, clean the bluing compound off both faces.
5. Apply anti-seize (nickel based) to the gate seal threads ONLY.



CAUTION

Carefully apply anti-seize to threads of the gate seal. Any anti-seize that enters the internal runner must be removed to prevent contamination of melt.

6. Using a socket wrench, re-install the gate seal being careful not to damage it.
7. Torque the gate seal to the appropriate value. Refer to "Gate Seal Torque Settings".



WARNING

High temperature on the nozzle. Wear safety clothing such as heat-resistant coat and heat-resistant gloves. Failure to do so may cause serious injury.

8. Check that the seal has bottomed out, heat nozzle to process temperature and re-torque seal.



WARNING

Failure to torque the gate seals at processing temperatures may result in leakage.

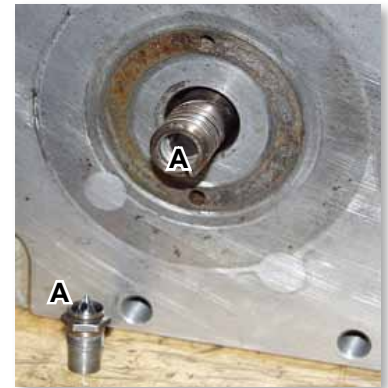


Figure 12-16 Cleaning Location Remove Plastic (A)



Figure 12-17 Nozzle Preparation

Sprint Gate Seal Maintenance

Reasons for Gate Seal Maintenance

- Tip damage
- Obstruction to melt flow
- Gate seal damage
- Tip wear

It is advisable to heat the nozzle to ensure the temperature condition is met to remove the gate seal.



CAUTION

Use the socket supplied in the tool kit to loosen the gate seal.

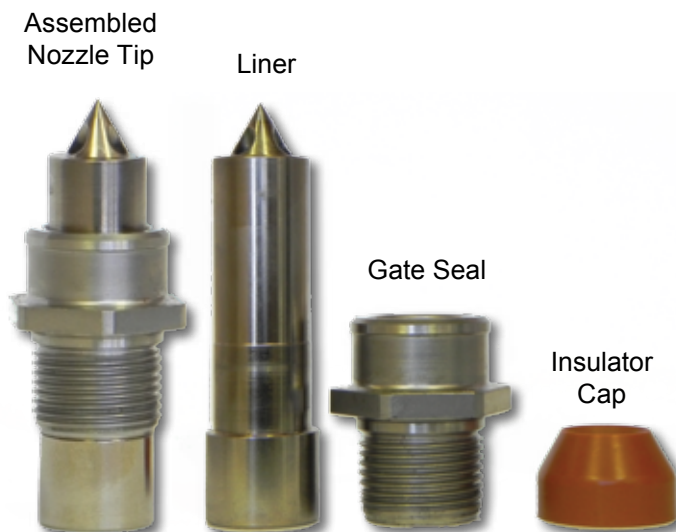


Figure 12-18 Sprint Gate Seal Components

Sprint Nozzle Tip Removal



IMPORTANT

The hot runner system must be turned off and cooled to below 38°C (100°F) before cavity plate is removed. The cavity plate can then be removed to expose the nozzle tips.

1. After gate seals are exposed by removing the cavity plate, heat nozzles only to 290°C (550°F) if nozzle thermocouples are present or set nozzle to 20% power until plastic softens in gate area.
2. Apply loosening torque to the gate seal using 6 point socket provided (16mm socket). If the seal starts to loosen, but starts to bind, apply some Pro-Long super lubricant to remove the gate seal more easily.
3. The gate seal, liner and insulator cap should come off the nozzle as an assembly. If the liner remains in the nozzle after the gate seal is removed, raise the nozzle temperature by 15°C (25°F) or 5% power and remove the liner using soft jawed pliers.
4. Turn off heaters after gate seal removal.



Figure 12-19 Tool Kit for Gate Seal Maintenance



Figure 12-20 Loosening Gate Seal

Sprint Nozzle Tip Installation

1. Clean all residual plastic from the nozzle threads and the liner/nozzle sealing surface.
2. Check the liner/nozzle sealing surface for damage. If damaged, lap the liner/nozzle sealing surface in a circular fashion with a hardened tool and 300 grit lapping compound.
3. After a smooth liner/nozzle contact surface is established, blue the liner to the nozzle surface to ensure proper mating.



Figure 12-21 Applying blue to liner surface

4. After ensuring good contact, clean bluing off both surfaces.
5. Apply nickel based anti-seize to the gate seal threads ONLY.



Figure 12-22 Applying anit-seize

6. Install gate seal / liner into nozzle using 6 point socket provided. Torque gate seal to 25-28 ft lb (34-38 Nm).



Figure 12-23 Torquing gate seal onto nozzle

Cleaning Nozzle Insulator Cap

1. Heat cap with heat gun.
2. Remove molten plastic and wipe remainder from insulator cap.



Figure 12-24 Cleaning Insulator Cap

Installing Nozzle Insulator Cap

1. Press fit insulator cap onto liner by hand.



Figure 12-25 Installing Insulator Cap

Checking Nozzle Tip Height

1. Correct nozzle tip height and nozzle reference point is found on the gate detail of General Assembly Drawing.
2. Assemble spacer blocks to same value as correct nozzle tip height.
3. Zero vernier to spacer blocks.
4. Move vernier to correct reference point on nozzle tip (per drawing).
5. Check that nozzle height is within drawing specification.
6. Repeat for each nozzle.



Figure 12-26 Checking Nozzle Tip Height

Latching

Introduction

There are two reasons latches are used in a mold:

- To tie the mold halves together for transportation and handling.
- To gain access between two mold plates which are screwed together during normal mold operation.

Latches are always used in pairs mounted on diagonally opposite sides of the mold to provide equal pull on the plates.

The latches are located on:

- The operator's side.
- Non-operator's side of the mold.
- Top and bottom of the mold.

Under no circumstances are plates to be pulled or handled with only one latch attached.

Latch locations are shown on the assembly drawings. During mold operation the latches must be removed from the mold and stored elsewhere.

Latching the Cavity Plate to the Core Half (Cold Half)

Use this procedure for reference purposes only. For latch locations, refer to the assembly drawings. For additional instructions on latching in the machine refer to the machine manufacturers manual.



WARNING

Make sure the machine has been locked out and tagged out in accordance to the machines documented procedures. Failure to do so may lead to serious injury or death.

1. Open the mold.
2. Ensure that the machine and hot runner controller has been locked out and tagged out.
3. Apply lock out / tag out to the machine power source and hot runner controller. Refer to the controller and machine manufacturers documentation for procedures.
4. Allow the mold to cool to room temperature. Continue to circulate the mold cooling water in all plates to cool the mold more quickly.

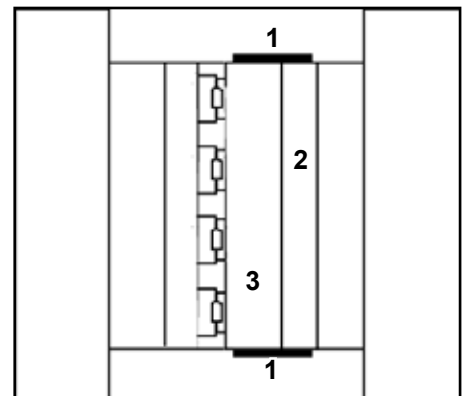


Figure 12-27 Latch Cavity Plate to Manifold Plate
1. Latches 2. Manifold Plate
3. Cavity Plate



WARNING

Make sure the lifting eyebolt, lifting chain and crane are rated to adequately support the weight of the plate(s). Failure to do so could cause serious injury.

5. If the mold has no leader pins, attach a crane that is rated to adequately support the weight of the cavity plate.


WARNING

Install latches before removing the cavity plate mounting screws. Failure to do so may lead to serious injury or death.

6. Latch the cavity plate to the manifold or manifold backing plate.
7. Check that the cavity plate hoses are long enough to allow the cavity plate to be latched over to the core half (cold half), without damaging the hoses.
8. Remove all cavity plate mounting screws.
9. Remove lockout / tagged out.
10. Place the machine in Mold Set mode.
11. Close the mold slowly.


WARNING

Make sure the machine has been locked out and tagged out in accordance to the machines documented procedures. Failure to do so may lead to serious injury or death.

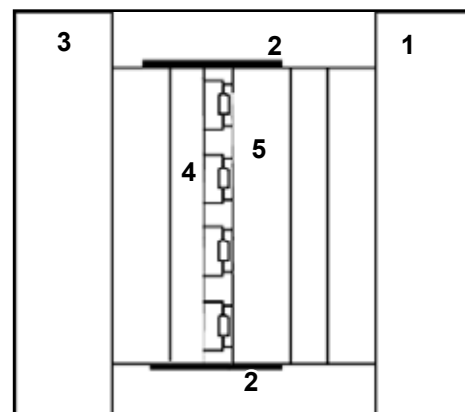


Figure 12-28 Cavity Plate to Core Plate
1. Stationary Platen 2. Latches
3. Moving Platen 4. Core Plate 5. Cavity Plate

12. Apply lockout / tagged out. Refer to machine manufacturers documentation for procedures.
13. Remove the latches.
14. Latch the cavity plate to the core plate or cold half.
15. Remove lockout / tagged out.
16. Check the machine is in Mold Set mode.
17. Open the mold moving the cavity plate away from the manifold plate.
18. Apply lockout / tagged out. Refer to the controller and machine manufacturers documentation for procedures.

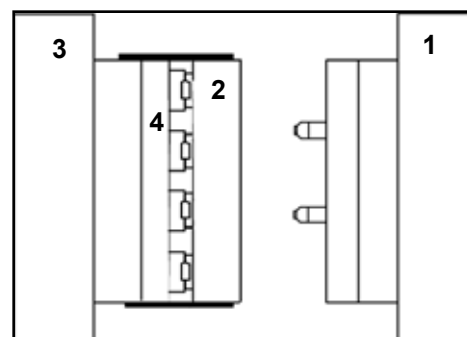


Figure 12-29 Latch Cavity Plate to Core Plate


CAUTION

The nozzles must be within 100°F (55°C) of mold temperature to prevent damage to hot runner and mold components. For cylindrical valve gated systems, valve pins should be in the open position prior to removal of the cavity plate to prevent damage.

Latching the Cavity Plate to the Manifold Plate (Hot Half)

**WARNING**

Make sure the machine has been locked out and tagged out in accordance to the machines documented procedures. Failure to do so could lead to serious injury or death.

**CAUTION**

The nozzles must be within 100°F (55°C) of mold temperature to prevent damage to hot runner and mold components. For cylindrical valve gated systems, valve pins should be in the open position prior to removal of the cavity plate to prevent damage.

1. Check the machine is locked out / tagged out.
2. Lubricate the guide pins on the hot half.
3. Remove lock out / tag out.
4. Check the machine is in Mold Set mode.
5. Slowly close the mold.
6. Check the machine has been locked out / tagged out. Refer to the controller and machine manufacturers documentation for procedures.
7. Remove the latches on both sides of the mold.
8. Latch the cavity plate to manifold plate or manifold backing plate.
9. Remove lock out / tag out.
10. Open the mold.
11. Check the machine has been locked out / tagged out. Refer to the controller and machine manufacturers documentation for procedures.
12. Install and torque the cavity plate mounting screws. Torque to required specifications, refer to assembly drawings for required torque settings.
13. Install hoses if required.
14. Remove latches from both sides of the mold.

Torque Settings

Gate Seal Torque Settings

Seal Torque Settings												
Gating Method	Femto-Lite		Femto		Pico		Centi		Deci		Hecto	
	Nm	ft-lb	Nm	ft-lb	Nm	ft-lb	Nm	ft-lb	Nm	ft-lb	Nm	ft-lb
E-Type Torpedo	8-9	6-7	8-9	6-7	16-18	12-13	27-30	20-22	34-38	25-28	47-54	35-40
Ext. E-Type Torpedo	8-9	6-7										
F-Type Torpedo	8-9	6-7	8-9	6-7	16-18	12-13	27-30	20-22	34-38	25-28	47-54	35-40
Hot Sprue			8-9	6-7	16-18	12-13	27-30	20-22	34-38	25-28	47-54	35-40
Extended Hot Sprue					16-18	12-13	27-30	20-22	34-38	25-28	47-54	35-40
Hot Valve			8-9	6-7	16-18	12-13	27-30	20-22	34-38	25-28	47-54	35-40
Bi-Metallic C-Sprue					16-18	12-13	27-30	20-22	34-38	25-28	47-54	35-40
Bi-Metallic Cylindrical Valve			8-9	6-7	16-18	12-13	27-30	20-22	34-38	25-28		
Bi-Metallic C-Valve					16-18	12-13	27-30	20-22	34-38	25-28	47-54	35-40
Spiral Hot Tip					16-18	12-13	27-30	20-22	34-38	25-28	47-54	35-40
Accu-Valve™			8-9	6-7	16-18	12-13	27-30	20-22	34-38	25-28		
TIT Edge					11-14	8-10	14-15	10-11	14-15	10-11		
Multi Tip							16-18	12-13	27-30	20-22		
Horizontal Hot Tip							15-18	11-13	15-18	11-13		
C-Sprue	8-9	6-7	8-9	6-7								
C-Valve			8-9	6-7								



NOTE

Gate seals are torqued at ambient (room) temperature at *Mold-Masters*. Please torque each seal at processing temperature to the torque value specified. This is to prevent material leakage from the gate seal.

System Screw Torques

Quality and length of screws must be as specified on *Mold-Masters* general assembly drawings.

Torque Chart for System Assembly Screws			
Metric	Torque Setting	Imperial	Torque Setting
M5	7 Nm	#10-32	5 ft lbs
M6	14 Nm	1/4-20	10 ft lbs
M8	20 Nm	5/16-18	15 ft lbs
M10	40 Nm	3/8-16	30 ft lbs
M12	60 Nm	1/2-13	45 ft lbs
M16	145 Nm	5/8-11	107 ft lbs
M20	285 Nm	3/4-10	210 ft lbs

Exception to the above, bridge manifold mounting screws should be torqued 1/3 higher than specified on general assembly drawings.

Torque Chart for Plate Assembly Screws			
Metric	Torque Setting	Imperial	Torque Setting
M5	10 Nm / 7 ft lbs	#10-32	9 Nm / 6 ft lbs
M6	16 Nm / 12 ft lbs	1/4-20	22 Nm / 16 ft lbs
M8	39 Nm / 29 ft lbs	5/16-18	48 Nm / 35 ft lbs
M10	77 Nm / 57 ft lbs	3/8-16	85 Nm / 63 ft lbs
M12	135 Nm / 100 ft lbs	1/2-13	209 Nm / 154 ft lbs
M16	330 Nm / 243 ft lbs	5/8-11	384 Nm / 283 ft lbs
M20	650 Nm / 479 ft lbs	3/4-10	678 Nm / 500 ft lbs

Component Torque Settings	
Valve Actuator	
Series 5500, 6500, 6600 and 6700	Torque Setting
Piston Top	20-27 Nm(15-20 ft-lbs)

NOTE

Torque sequence and step torquing:

It is recommended that system screws be torqued in a standard bolt pattern and that the specified torque is achieved in 3 steps (1/3, 2/3 and full torque).

Section 13 - TIT Edge Gated System

Introduction

The following section contains procedures on non-standard components.

TIT Edge Gated System

Edge gated systems are supplied with gate seals that are oversize. They must be ground prior to installing the nozzle into the nozzle well bore. (Minus heat expansion).



NOTE

Exception - Gate seals supplied without the gate. The gate must be placed into gate seal after the seal is ground to the final dimension. Refer to gate detail on GA drawing.



NOTE

Heat expansion of the nozzle must also be taken in to consideration.

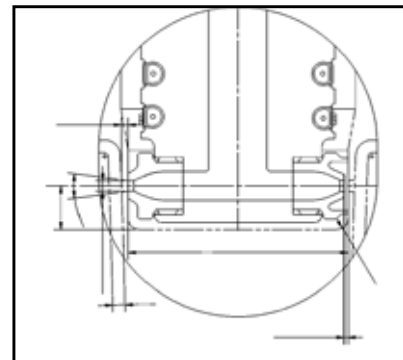


Figure 13-1 TIT Edge Gated System

TIT Edge Gate Seals

The following procedure applies to TIT Edge nozzles only. The gate seal have an M6 thread.

Removing the Gate Seal



NOTE

If the cavity plate is easily removed you can access the nozzle seals while still in the system. Hot runner systems must be cold before the cavity plate can be removed.

1. Apply penetrating oil to the threads.
2. Heat the nozzle to processing temperature to melt any residual plastic that may be in the gate seal area.
3. When the nozzle approaches set temperature, use *Mold-Masters* supplied socket to remove the seal.



NOTE

Cylindrically ground gate seals cannot be reinstalled.

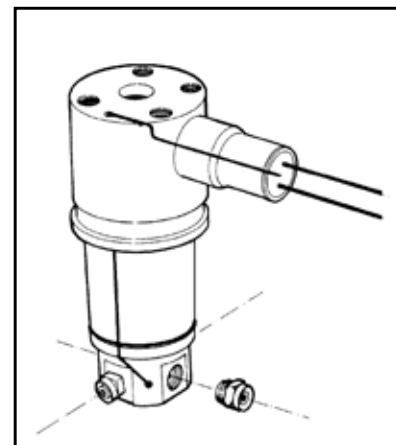


Figure 13-2 TIT Edge Gate Seal

Section 14 - Accu-Line System

Accu-Line™

Accu-Line Body Assembly

- 1 - Socket Head Cap Screw
- 2 - Actuator Cylinder Top
- 3 - O-Ring, Viton
- 4 - O-Ring, Viton 5 - Guide Ring
- 6 - O-Ring, Viton 90 Durometer
- 7 - Guide Ring
- 8 - Actuator Piston
- 9 - Outer Cylinder Housing
- 10 - Socket head Cap Screws
- 11 - Actuator 24" Con. Hose w/Fittings
- 12 - Actuator Heated Body
- 13 - Actuator Valve Pin Holder
- 14 - Socket head cap Screws
- 15 - Valve Pin
- 16 - Dowel Pin
- 17 - Socket head Cap Screw
- 18 - Accu-Line Bushing
- 19 - Nozzle
- 20 - Liner
- 21 - Gate Seal

REFER TO GENERAL ASSEMBLY DRAWINGS FOR ACTUAL SIZES

Piston Parts List:

- A) HYORGxx (Viton o-ring)
- B) PS00xx (3 piece piston seals)
Each containing: 1 – Backup ring with split
1 – Viton o-ring
1 – Hard ring
- C) GUIDERINGxx (Guide ring)

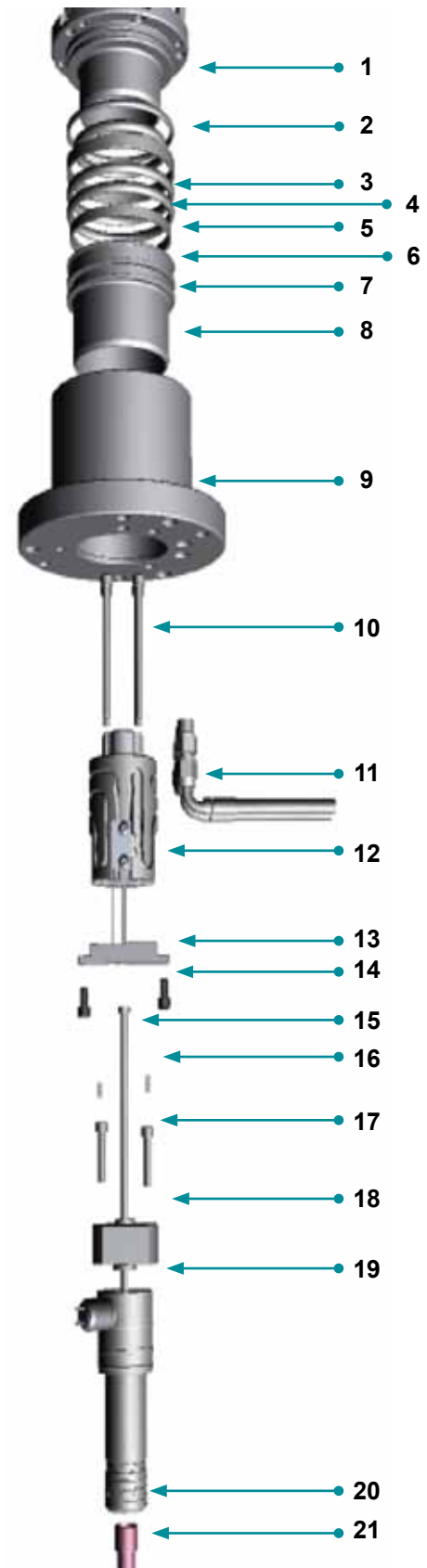
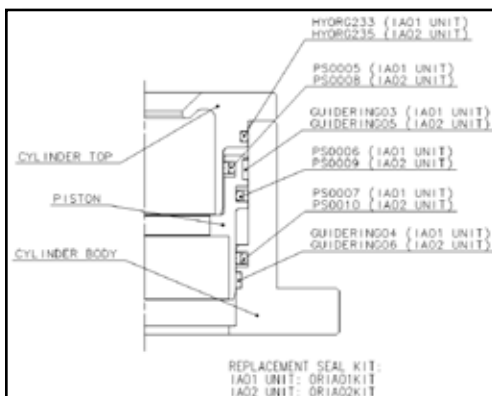


Figure 14-1 Accu-Line Body Assy

Accu-Line Assembly Procedure

1. Check components against the parts list.



Figure 14-2

2. Put cylinder backup washer and O-ring into cylinder body groove. Bend the cylinder hard ring into a kidney shape and insert into position in cylinder body.



Figure 14-3

3. Carefully push the protruding segment of the hard ring into the groove and reshape it using your finger. Make sure it seats firmly in the groove.



Figure 14-4

4. Repeat steps 1 - 3 to install inner seal into the piston.



Figure 14-5

5. Install piston backup washer and O-ring into the designated outer groove. The back up washer should be placed on the shorter side of the piston. Place one side of piston hard ring into position and using your fingers carefully push it into the groove. Apply small amount of lubrication to O-ring and the inner side of the hard ring to help assembly.

**CAUTION**

Do not use any tools. This may cause overstretching of the hard ring.



Figure 14-6

6. Insert piston (with seals and guide ring) into the cylinder body (with seal and guide ring). Apply a small amount of lubrication to all outside faces of seals prior to this step to help assembly.



Figure 14-7

7. Ensure that timing marks on both components are aligned.



Figure 14-8

8. Make sure installed seals engage into guiding chamfer. Press piston smoothly and gently, applying even force.



Figure 14-9

9. Insert O-ring into cylinder top and assemble it to cylinder body.



Figure 14-10

10. Torque fasteners to specifications detailed in GA drawings.



Figure 14-11

11. Turn assembled unit over and attach actuator connection hose fittings to the supply ports. Tighten to specifications detailed in the GA drawing.



Figure 14-12

12. Attach gate seal and liner to nozzle. Tighten to specs detailed in the GA drawings. Attach nozzle thermocouple.



Figure 14-13

13. Attach valve bushing. Tighten to specifications detailed in the GA drawing.



Figure 14-14

14. Slide the valve pin into the nozzle assembly.



Figure 14-15

15. Attach the 2 hollow sleeves to the valve bushings (Hecto nozzles only).



Figure 14-16

16. Attach the heater body over the assembly. Tighten to specifications detailed in the GA drawing. The thermocouple can be inserted by removing the wire retainer holding terminal end and bending into the thermocouple groove



Figure 14-17

17. Slide the valve pin holder into the heater body slot and over the valve pin head.

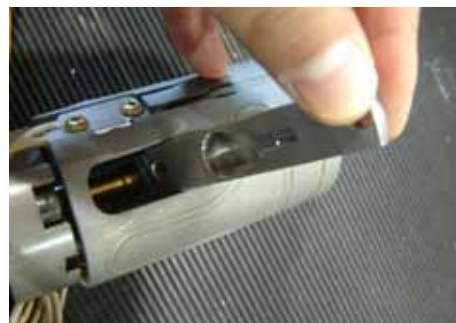


Figure 14-18

18. The valve pin holder should be locked with and move together with the valve pin.



Figure 14-19

19. Carefully place the nozzle assembly into the hydraulic unit as shown.



Figure 14-20

20. Ensure that the nozzle terminal end is correctly oriented.



Figure 14-21

21. Secure the valve pin holder to piston. Tighten to specifications detailed in the GA drawing.



Figure 14-22

22. Cut pin to calculated length, as specified in the GA drawing. Refer to "Valve Pin Finishing of Tip".

23. Assemble inside mold and verify assembly and all connections for accuracy.



Figure 14-23

Section 15 - Melt-Disk System

Melt-Disk[®]

Introduction

We would like to take this opportunity to thank you for purchasing a *Mold-Masters* Melt-Disk system. The purpose of this manual is to assist users in the integration, operation and maintenance of *Mold-Masters* systems. This manual is designed to cover most system configurations. For additional information, please contact your representative or a *Mold-Masters* office.

Safety

Please see Section 3 for important safety information.

The responsibility for the safety of personnel remains exclusively with the employer. It is the obligation of the employer to properly train and instruct its personnel in the safe operation of equipment including maintenance and the purpose and proper use of all the safety devices. In addition, the employer must provide its personnel with all necessary protective clothing, including such items as a face shield and heat resistant gloves. Any instructional material provided by *Mold-Masters* for the operation and maintenance of equipment, does not in any way absolve the employer from fulfilling these obligations and *Mold-Masters* disclaims liability for injury to personnel using equipment supplied.

Notices

Notices throughout this manual indicate additional information that must be performed or observed.



WARNING

Safety warning indicates a potentially hazardous situation, which if not avoided, could result in serious injury or death.



CAUTION

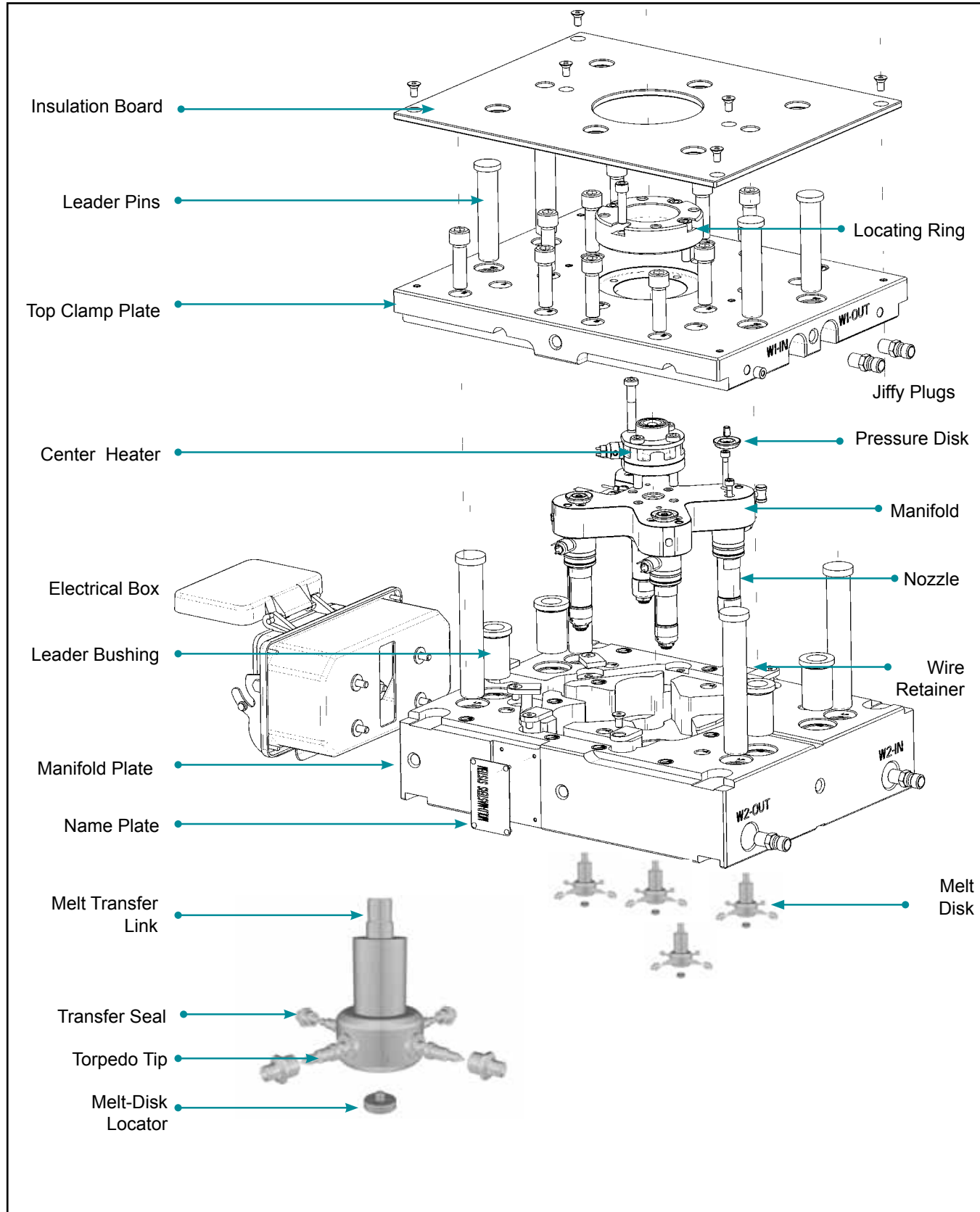
Caution indicates that damage to equipment is possible.



NOTE

Important indicates useful additional information or is used as a reminder for important information.

System with cast in heater element



Hot-Half Pre-Assembly - Melt-Disk Preparation / Cleaning

All nozzles, manifolds and components must be free of the rust inhibitor applied at the factory.

1. Disassemble the Melt-Disk assembly.
2. Wipe down the Melt-Disk.
3. Remove the part and wipe clean. If necessary, use a cotton swab to clean narrow interior surfaces or screw threads. For larger surfaces, such as mold plates use thinner in spray form to clean channels and recesses.

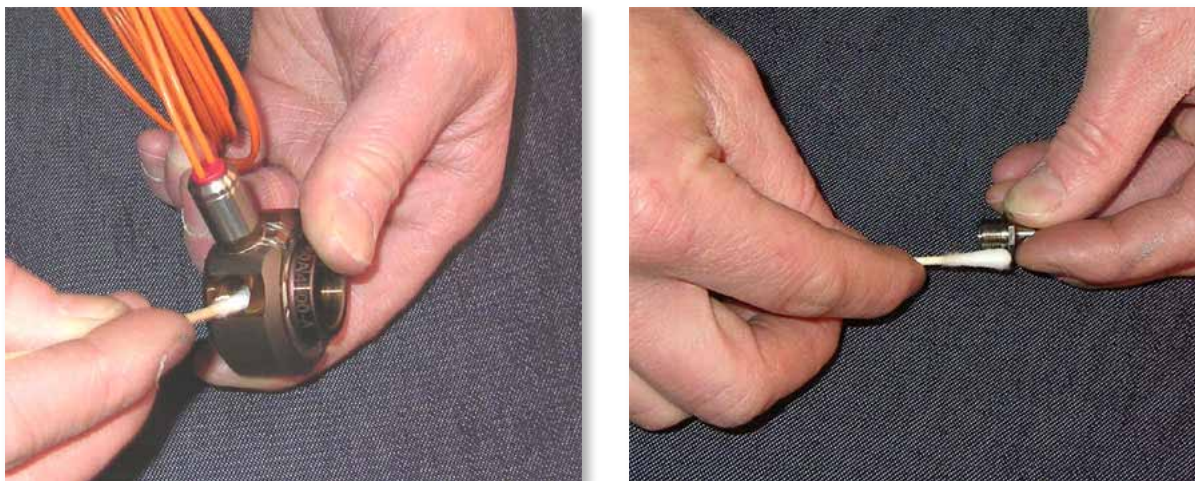


Figure 15-1 Cleaning Parts

4. Anti-seize the threads of the gate seals, using *Mold-Masters* supplied compound.

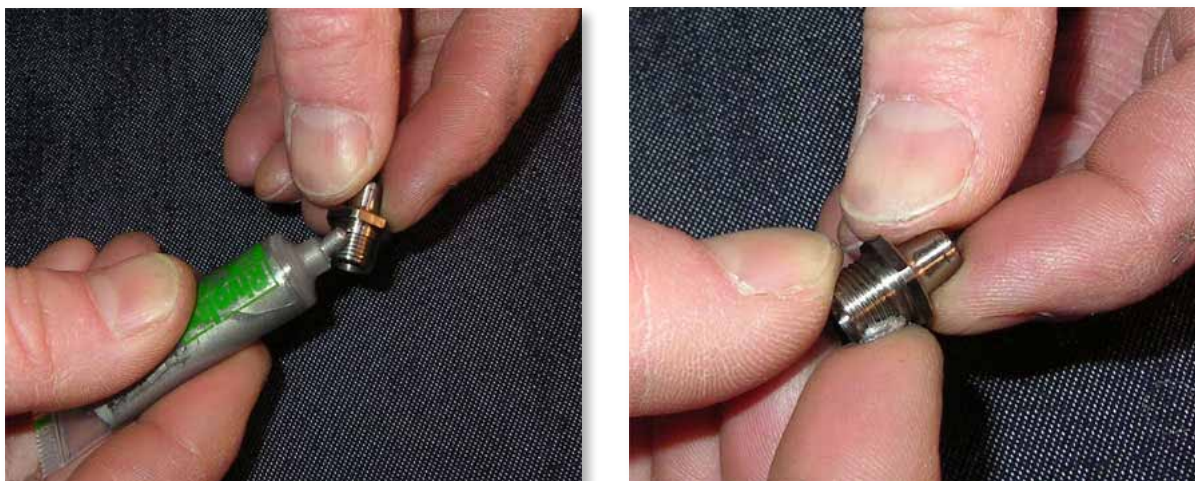


Figure 15-2 Anti-Seize Compound Application

5. Insert the pointed end of the tips (torpedoes) into the threaded end of the gate seal.



Figure 15-3 Assembling Gate Seal

6. Thread the gate seal assembly into the Melt-Disk. Secure the Melt-Disk in a soft vice and torque gate seals in the cold condition to value specified below or in the General Assembly Drawings. Do not over tighten the vice. Ensure none of the components are damaged.

• Thread size	• Imperial	• Metric
• M9	• 10 - 11 ft lbs	• 14- 15 Nm

7. Torque gate seals in heated condition at processing temperature as specified in the general assembly drawings.



CAUTION

Failure to torque the gate seals at processing temperatures may result in leakage.

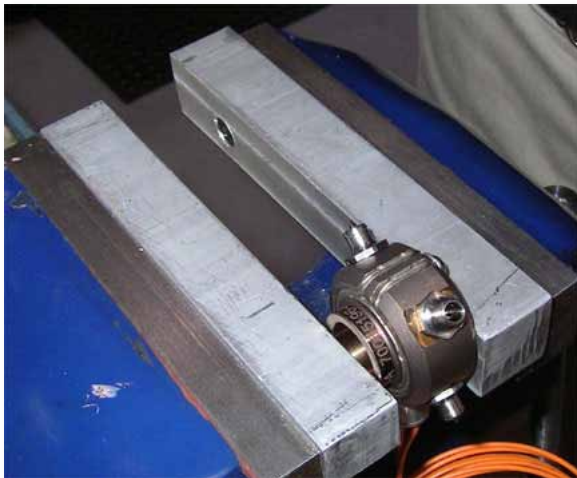


Figure 15-4 Torquing Gate Seals

Nozzle Thermocouple Assembly

1. Although not necessary, a thermal compound may be applied to the tip of the thermocouple.
2. Connect the thermocouple as specified in the general assembly diagram. See also "Section 5 -Assembly".

Melt-Disk Thermocouple Assembly

1. Remove the thermocouple retaining screw from the Melt-Disk.



Figure 15-5

2. Insert the thermocouple tip into the thermocouple hole. Thermocouple must bottom out in the hole.



Figure 15-6

3. Bend the thermocouple back 90°.



Figure 15-7

4. Secure the thermocouple with the screw from #1.



Figure 15-8

5. Use heat resistant tape to secure the nozzle wires and thermocouple wires just above the insulator pod.



Figure 15-9

6. Prepare all remaining Melt-Disks the same way and set aside.



Figure 15-10

Assembly of Melt-Link to Nozzle

1. Anti-seize the threads of the Melt-Link, using *Mold-Masters* supplied compound.



Figure 15-11

2. Thread the Melt-Link into the nozzle.
3. Torque the Melt-Link COLD to the value specified in the general assembly diagram.



Figure 15-12

Manifold Cavity Preparation

1. Calculate the following dimensions at ambient (room) temperature:

- a. Measure the depth of the nozzle bore "a" from the top of the manifold plate to the nozzle support base.

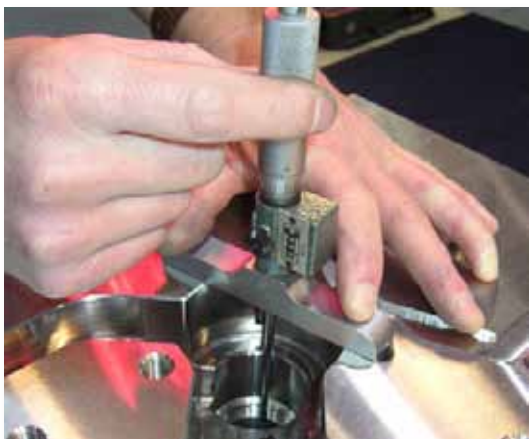
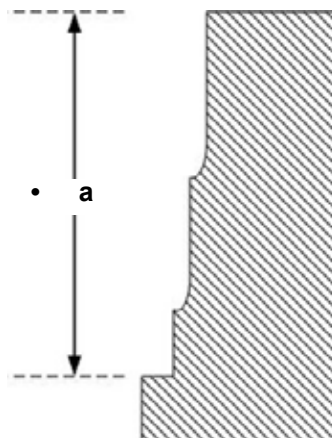


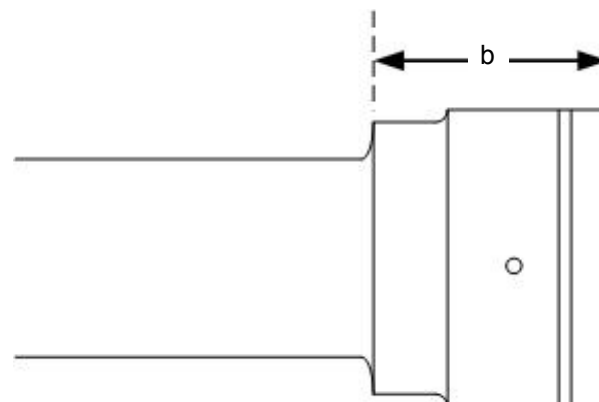
Figure 5-13 Calculating Nozzle Bore Depth "a"



- b. Measure the top section of the nozzle flange "b".



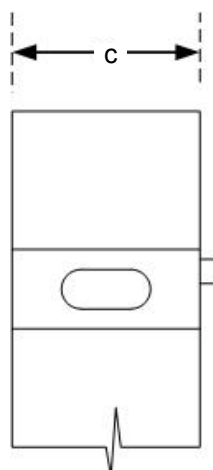
Figure 5-14 Calculating Nozzle Flange Height "b"



- c. Measure the manifold thickness "c".



Figure 5-15 Calculating Manifold Thickness "c"



Manifold Cavity Preparation - Con't.

2. Calculate **Pressure Disk height "d"** = $a - b - c - \text{air gap}$.
This is the value ("d") that's required for correct assembly. Refer to the general assembly drawing for reference values, such as the air gap.
3. The actual height (thickness) of the supplied pressure disk "e" will be of a value that's higher than the value "d". Calculate the difference, and then divide by 2. This is the value that will need to be ground from each side of the pressure disk.

Pressure Disk Details

1. Install the manifold to the nozzle.
2. Refer to the general assembly drawing for pressure disk dimensions before calculating the pressure valve disk height.
3. Pressure disks are supplied oversize in height, grind equal amounts from each side to cold clearance and retain maximum strength of the 'V' form. Some systems require a larger air gap. Refer to the General Assembly drawing.
4. Remove the sharp corners after grinding and clean the disk well to ensure no grinding dust remains on the disk.
5. Install the pressure disk spring dowel to the manifold.
6. Install the pressure disk to the manifold.

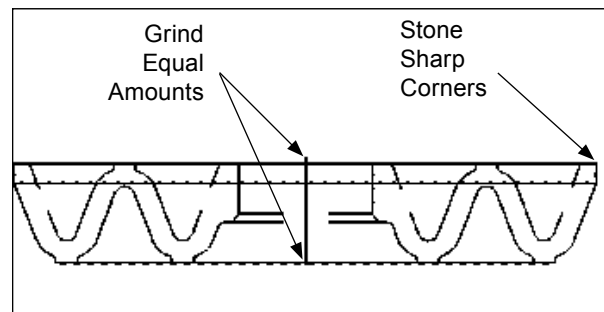


Figure 5-16 Pressure Disk Details

Example Calculations

Nozzle bore depth "a": 91.39 mm
 Nozzle flange height "b": 43.16 mm
 Manifold thickness "c": 43.16 mm
 Air gap as noted on drawing: 00.05 mm

Pressure disk height "d": $91.39 - 43.16 - 43.16 - 0.05 = 5.02 \text{ mm}$

Supplied pressure disk "e": 5.10 mm

Difference between supplied pressure disk "e" and required pressure disk "d": $5.10 \text{ mm} - 5.02 \text{ mm} = 0.08 \text{ mm}$

Material to be removed from each side of the pressure disk: $0.08 \text{ mm} \div 2 = 0.04 \text{ mm}$

Nozzle bores and pressure disks must be within tolerances specified in the general assembly drawing.

Final Assembly of the Manifold Plate

1. Insert each prepped nozzle into the nozzle cavities. Make sure the wires are not bent or pinched anywhere. Place a zone number on each wire and thermocouple. Group and tape wires for each zone and plug. Feed all wires through the wire channels towards the electrical box channel.



NOTE

Check GA drawing for information for your system.

2. For some systems locators are supplied oversize (X) and must be ground to the same level as the top of the nozzles. Remove the material from the bottom face of the locator (FACE Y). This will allow SURFACE (A) and SURFACE (B) to be at the same level in the cold condition.

For other systems there is a long distance between the manifold locator and the nozzles and the manifold locator needs to be higher than the nozzles (approximately 0.03 mm). Before grinding the manifold locator it is strongly advised to check the GA drawing.

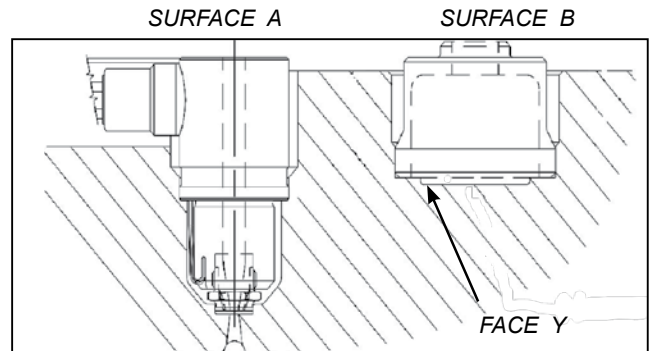


Figure 5-17 Locator Surface

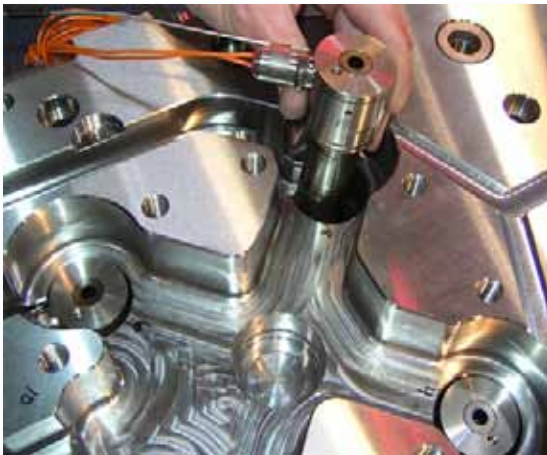


Figure 5-18 Nozzle Insertion

3. Feed the wires back through the wire channel in the mold base to the mold plug. Do not cut the wires until the remaining components are installed.



Figure 5-19 Manifold Locator Adjustment

Electrical Box Preparation

1. Use washers to offset the electrical box from manifold plate. This prevents the top plate from bumping into the electrical box during assembly. Feed all wires through as shown. Trim the wires back, noting the number tags assigned to each wire. **Do not cut these tags off.**



Figure 5-20 Electrical Box Mounting Detail

Final Mold Plate Assembly

1. Using appropriate tools, place the manifold into the manifold cavity of the manifold plate, as shown below. Ensure that no electrical or thermocouple wires are pinched, frayed or bent. The backplate and heater assembly are shown already assembled (normally assembled at a later step).
2. Secure wires to the manifold plate using wire retainers.



Figure 5-21 Inserting Manifold into Manifold Plate



WARNING

Make sure the lifting eyebolt, chain and crane can support the weight of the manifold. Failure to do so could cause serious injury.

Final Mold Plate Assembly - Con't.

3. If required, attach a crane of sufficient lifting capacity to the manifold.
4. Place the manifold on top of the nozzles and locator.
5. Place the pressure disks (machined to proper thickness as detailed in section "*Manifold Cavity Preparation*") atop the manifold.
6. Connect ground wire and manifold thermocouple.



Figure 5-22 Manifold Preparation

System Screw Torques

Quality and length of screws must be as specified on *Mold-Masters* general assembly drawings.

Torque Chart for System Assembly Screws			
Metric	Torque Setting	Imperial	Torque Setting
M5	7 Nm	#10-32	5 ft lbs
M6	14 Nm	1/4-20	10 ft lbs
M8	20 Nm	5/16-18	15 ft lbs
M10	40 Nm	3/8-16	30 ft lbs
M12	60 Nm	1/2-13	45 ft lbs
M16	145 Nm	5/8-11	107 ft lbs
M20	285 Nm	3/4-10	210 ft lbs

Exception: Bridge manifold mounting screws should be torqued 1/3 higher than specified on GA drawings.

Installing the Manifold Thermocouple

1. Although not necessary, a thermal compound may be applied to the thermocouple tip to ensure a good contact.
2. Insert the thermocouple into the bore. Check that the thermocouple is touching the bottom of the hole.
3. Press down on the thermocouple and gently bend the thermocouple sheath 90°.
4. Check that the thermocouple sits in the manifold cutout.
5. Install the thermocouple washer and screw.
6. Install a zone number on each wire and thermocouple.
7. Organize and tape together wires for each zone and plug.
8. Feed the wires back through the wire channel in the mold base to the electrical box and secure with wire retainers.

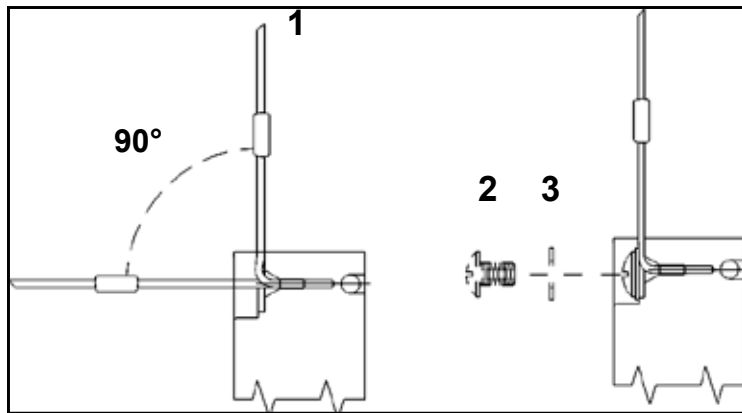


Figure 5-23 Thermocouple Installation
1. Thermocouple 2. Screw 3. Washer 4. Assembly

Manifold Center Heater (Optional)

1. Attach the back plate to manifold plate as follows:
 - a. Snug up each fastener but do not tighten.
 - b. Once all fasteners are snug, torque each to 20 ft. lbs.
2. Place the center heater over the back plate. Attach the cover plate and torque to 20 ft. lbs. Run the wires through the appropriate channel into the electrical box.



Figure 5-24 Heater and Back Plate Assembly

Final Assembly

1. Rub a small amount of high temperature grease on the clamp plate guide pins, and lower onto manifold plate. Ensure no wires will be pinched.



WARNING

Make sure the lifting eyebolt, chain and crane can support the weight of the clamp plate. Failure to do so could cause serious injury.

2. Dab anti-seize compound on tip of the fasteners. Tighten from the center of the plate out towards the edges.

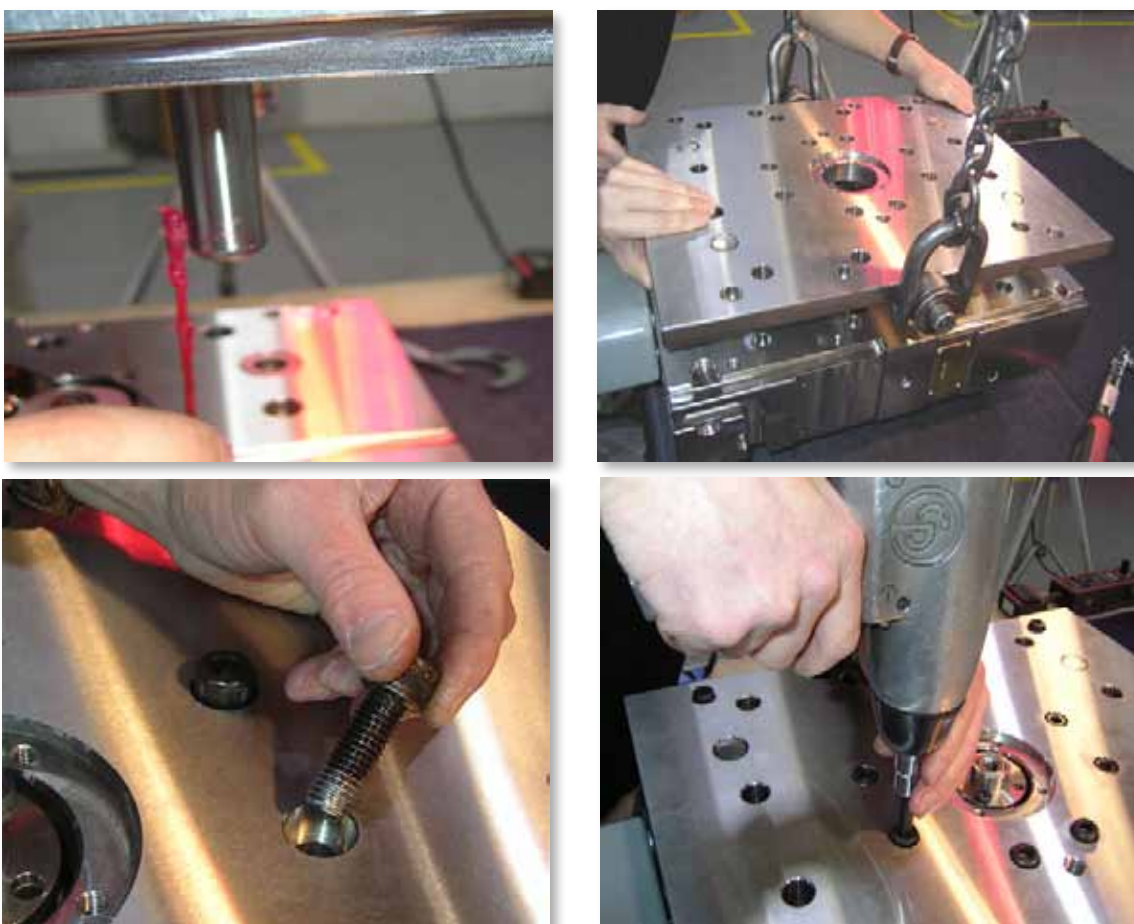


Figure 5-25 Securing the Clamp Plate

- Torque each fastener to value specified for plate assembly screw on the general assembly drawings. Attach the locating ring and tighten.



Figure 5-26 Securing the Cover Plate

- Flip assembled hot half over. Use appropriate sized wooden blocks to rest hot half to prevent damage to nozzles and other components.



WARNING

Make sure the lifting eyebolt, chain and crane can support the weight of the manifold. Failure to do so could cause serious injury.

- Attach connector pins ends to each wire and crimp. Configure electrical connector as specified in engineering print.



Figure 5-27 Electrical Connector Assembly

Assemble Melt-Disk to Nozzle

- Assemble Melt-Disks onto the nozzles according to mold design.
- Ensure the sharp edge of the melt link does not get damaged.



Figure 5-28

Melt-Disk System Start Up & Shut Down

Also refer to Section 8 System Start Up & Shut Down and the MZ *TempMaster* controller manual.

Start Up

**NOTE**

When running thermally sensitive materials, use a thermally stable material as recommended by the material supplier for the initial start-up.

1. Turn on the machine barrel and mold cooling system.
2. Prior to start-up, ensure the:
 - Machine barrel is up to processing temperature.
 - Mold cooling is on and at cooling temperature.
3. Heat manifold zones and Inlet to processing temperature.
4. Heat Melt-Disks to processing temperature.
5. Heat nozzles to processing temperature. A small amount of material may weep at this stage.
6. Allow to heat soak at least 10 minutes.
7. Fill system under low pressure extrude (using screw rotation).
8. Set Melt-Disk temperature at least 10°F lower than nozzles.

**NOTE**

For hot runner systems using heater plates, allow 10 minutes of soak time after the system reaches processing temperature.

**CAUTION**

Failure to follow the above procedure may result in leakage/damage occurring in the hot runner.

**WARNING**

When the mold is open never inject material through hot runner system under high pressure. Failure to do so can result in serious injury or death.

Shut Down

**NOTE**

For horizontal tips, refer to the MZ controller operating manual.

1. Maximize decompression stroke prior to shut down. This will minimize drool at start up when there is limited gate cooling.
2. Reduce nozzle temperatures to 300°F (150°C).
3. Reduce Melt-Disk temperatures to 300°F (150°C).
4. Turn off all zones.

**NOTE**

Thermally sensitive materials should be purged from the hot runner system prior to shut down using a thermally stable material with a similar processing temperature. For example, a system running PVC should be initially started and subsequently shut down on LDPE.

Disassembly for Maintenance



NOTE

Before shutting down the molding machine and mold, use maximum screw decompression to remove as much molten plastic from the hot runner system as possible.

1. Disassemble mold to expose the Melt-Disk. Plate/insert removal to be done with all components in the cold condition.
2. Melt-Disks should be heated to 250 - 280°F before removal. The Melt-Disk should be removed as soon as it reaches set-point. The EXTOOLAS01 can be used to assist with the Melt-Disk removal.

Melt-Disk Reassembly after Maintenance

1. All sealing surfaces are to be clean and inspected for defects.
2. The inside bore of the Melt-Disk is to be free of material so that when it is installed to the Melt-Link, there is no interference.
3. The Melt-Disk is to be installed cold onto a cold Melt-Link.

Section 16 - Troubleshooting

Introduction

This troubleshooting information assumes that the hot runner has been operational.

Basic rules for troubleshooting are:

- Define the problem; what is seen is only a symptom of the underlying problem.
- Develop a method to isolate the problem.
- Test one item at a time to verify results.
- Monitor the final solution to verify that the problem has been solved. Repeat occurrences of the same symptom may indicate other problems.
- Document the solution so that a repeat occurrence can be solved quickly.
- Consult other resources to augment the troubleshooting information in this manual. One of the best resources may be your resin supplier.



WARNING

Extreme heat. Avoid contact with heated surfaces. To avoid serious burns wear safety clothing consisting of a protective heat resistant coat and heat-resistant gloves. Use adequate ventilation for fumes. Failure to do so could result in a serious injury.

Moisture Related Issues

Many common molding issues can be directly attributed to moisture contamination of the production resin. Generally, manufacturing resin is supplied from the manufacturer in ready to process pellets that are in sealed, airtight containers. Follow manufacturers storage instructions, keeping containers sealed until ready to use. Prior to using pellets, follow the drying instructions, as provided by the resin supplier and molding machine manufacturer (if applicable).

Resin Moisture Contamination

Moisture can be introduced into the resin in many ways:

- During transportation
- Environmental exposure (aging)
- Malfunctioning heater/dryer
- Extreme humidity in atmosphere
- Inadequate or malfunctioning facility HVAC

Resin Drying Issues

During the drying stage of the resin (if applicable), ensure that:

- The resin pellets are not overpacked
- Adequate air circulation is present
- The drying system is properly sealed, according to manufacturers instructions

Importance of Pre-Drying Resin

Thermoplastic resins can be hygroscopic, able to absorb moisture from the air. Under normal processing conditions, this can lead to degradation of the polymer during molding. Breakage of polymer chains changes the properties, resulting in possible blisters, streaks, splay or other defects described in this section.

Recycled resins can have higher hygroscopic properties due to greater surface area and should be dried separately from fresh resins.

If moisture issues are ruled out, continue with the troubleshooting tables in the following pages.

Pre-Molding Precautions

Prior to commencing production, ensure that the following conditions have been met. This will greatly reduce any future need to troubleshoot defective production.

History

- Review any documentation associated with your batch job regarding the recipe using the mold, molding machine, thermoplastic resin, environmental setting, etc.
- Review comments, notes, logbooks, blogs, and anything other resource material that pertains to the batch job.
- Verify that all settings such as all time, temperature, pressure, material, etc. are correct.

Material

- Ensure that the thermoplastic resin to be used is the right grade, and has been stored and/or prepared/dried, etc, according to manufacturers specs.
- Verify that the pigment/dye to be used meets manufacturers specifications, and is compatible with the resin/molding machine/mold.
- Verify the correct recycle ratio and adjust settings accordingly.

Hardware

- Make sure the mold has been properly stored, and is dry, clean, free of rust, dirt, moisture, residual resin, pigment and any protective coating.
- Check that the temperature controller meets requirements, and is fully tested and operational.
- The injection molding machine has been properly maintained, cleaned, lubricated; tolerances and dimensions verified.
- Make sure that the nozzles, cylinders, valves, gates, and any other variable that is appropriate for the batch job has been chosen.

Settings

Ensure that all batch job parameters are correct:

- Temperatures
- Pressures
- Injection Speed
- Back Pressure

Establishing Root Cause

This section is to be used as a reference tool only.

When a system that has been set up according to specification and was functioning normally suddenly produces sub-standard parts, the data in the following pages may be used to determine the possible cause, but only should be used as a guide.

A correct set up procedure that has been proven in will produce parts that meet design tolerances and specifications. A sudden change in any parameter indicates a possible fault. Rather than modify other settings to compensate for this variation, it is advisable to determine which of the original settings has changed.

Fault Identification

The operator will need to evaluate all the possible conditions which may have caused the defect.

- Identify the problem
- Determine the frequency
- Is the problem random or in the same location
- Review past history logs for similar occurrences and resolutions.

Review the machine settings to ensure that there is no variation from the original set-up which was producing standard parts.

- | | |
|--------------------|----------------|
| • injection speed | • melt heating |
| • screw speed | • locking |
| • melt temperature | • cushion |
| • back pressure | • mold heating |

For a more thorough analysis of the defect, refer to the **Troubleshooting Section** in the following pages.

Defect Types, Causes and Remedies Index

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Parts have Dark Specks

The finished product contains dark particles.
(When transparent resins are usually used.)

Probable Cause:

Molding Machine



- Offline for extended period
- Barrel offline for extended period
- Barrel improperly purged
- Contamination in plasticizer
- Wrong nozzle
- Use of wrong screw

Mold



- Gate and/or runner has dead spots

Material



- Physical contamination of raw material
- Chemical contamination of raw material
- Particulate contamination from machine barrel

Solution (In sequence):



- Purge system with appropriate material
- Trace source of contamination and repair, remove or discard
- Adjust melt temperature if necessary
- Inspect for dead spots: gates; runners; nozzle; back flow valve
- Inspect feed screw for degradation



Parts have Blisters and/or Bubbles

The finished product contains small gas or air filled pockets or cooling voids.

Probable Cause:

Molding Machine



- Low Injection Pressure
- Back flow valve malfunctioning
- Suck-back cycle too long
- Rapid plasticizing
- Trapped air in feed
- Feed error

Mold



- Trapped or volatile gas
- Low mold temperature
- Poor thin/thick transition phase
- Inadequate venting

Material



- Overheating of resin

Solution: (In sequence)



- Verify control and/or holding pressure
- Increase back pressure
- Increase mold temperature
- Inspect back flow valve
- Ensure proper venting
- Increase gate size
- Decrease vent land length



Parts have Flow Marks

The finished product exhibits blush and flow marks, due to variations in material temperature from gradients between the machine nozzle and mold sprue bushing. Cold material in the nozzle tip section results in a halo around the direct sprue.

Probable Cause:

Molding Machine



- Wrong injection speed
- Wrong injection pressure
- Hold pressure too long

Mold



- Insufficient mold cooling
- Temperature of mold too high around the gate
- Temperature of mold too cool
- Gate size is too small
- Gate is in wrong location
- Land length of gate is too long

Material

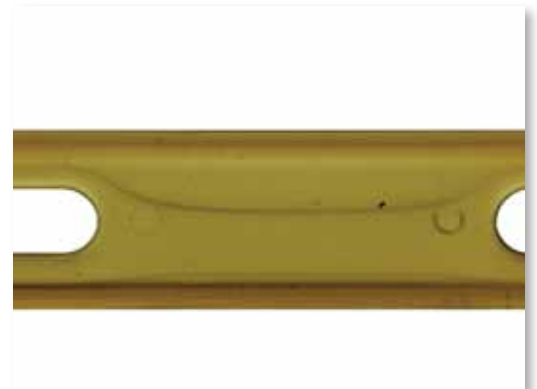


- Melt temperature is too low

Solution (In sequence):



- Adjust injection speed
- Add a large cold slug area
- Add cold wells at the end of the runner system
- Use hot sprue bushing
- Identify and eliminate dead pockets or sections



Parts have Burn Marks

The finished product display brown streaks. This is from the material being overheated due to trapped air (diesel effect), which can lighten or darken the color.

Probable Cause:

Molding Machine



- High injection speed
- Backflow/check ring valve malfunctioning
- High back pressure

Mold



- Trapped or volatile gas
- Burning due to friction
- Incorrect sprue diameter

Material



- Overheated/underheated melt, possible shear

Solution: (In sequence)



- Clear blocked vent channels
- Lower injection speed
- Lower injection pressure
- Check heater functionality
- Check thermocouple functionality
- Reduce feed screw rotation
- Reduce melt temperature
- Increase mold cavity venting
- Enlarge gate
- Change gate position and/or size



Parts are Delaminating

The finished product is separating into layers that can be peeled off; surface layers are flaking off. Insufficient layer bonding as a result of high shear stresses; non-homogenous material.

Probable Cause:

Molding Machine



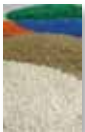
- High injection speed

Mold



- Cold mold
- Gate has sharp corners
- Sharp corners causing shear heat

Material



- Physical contamination of raw material
- Chemical contamination of raw material
- Melt too hot; poor melt
- Incompatible color dye
- High percentage of recycled material



Solution (In sequence):



- Melt temperature increased
- Mold temperature increased
- Injection speed decreased
- Contamination eliminated
- Regrind ratio adjusted
- Resin moisture content adjusted/changed
- System purged
- Sharp corners at gate reduced

Parts have Dimensional Irregularities

The finished product is of a different dimensional value than originally designed, or previous production.

Probable Cause:

Molding Machine



- Low injection pressure
- Short hold pressure time
- Damaged back-flow/check ring valve
- Short cycle time
- Cylinder clearance too big
- Nozzle heaters malfunctioning

Mold



- Temperature setting is too high
- Small gate size resulting in wrong pressure
- Incorrect gate location
- Incorrect mold configuration/size

Material



- Generally not a material related issue unless excessive regrind is used

Solution: (In sequence)



- Increase the injection pressure
- Increase the cooling time
- Increase the mold temperature
- Ensure cycle time is consistent
- Monitor molding machine for irregularities
- Balance regrind ratio
- Increase gate size
- Decrease gate land length
- Balance the runner and/or gate system
- Decrease cavity quantity



Parts are Discolored

The finished product varies in color on different surfaces.

Probable Cause:

Molding Machine



- Contamination

Mold



- Incorrect sprue diameter
- Inadequate venting

Material



- Physical contamination of raw material
- Chemical contamination of raw material
- Melt too hot; poor melt
- Incompatible color dye
- Residence time too high

Solution (In sequence):



- Heating cylinder purged
- Resin temperature lowered by:
 - a. reducing cylinder temperature
 - b. reducing screw speed
 - c. reducing back pressure
- Nozzle temperature decreased
- Residence time adjusted
- Regrind ratio adjusted
- Cycle time adjusted
- Check for external contamination sources
- Ensure proper cooling in all areas.
- Increase mold venting



Parts Contain Flash

Also known as "Fins" or "Spew".

The finished product contains a thin film of material attached at the mold parting line.

Probable Cause:

Molding Machine



- Low clamping pressure
- High injection pressure
- High injection speed

Mold

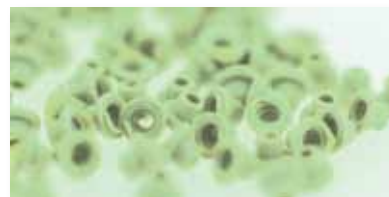


- Inadequate mold supports
- Low clamping force
- Damaged mold
- Projected area too large for machine capacity

Material



- Low melt viscosity
- High melt temperature



Solution: (In sequence)



- Reduce the injection speed
- Reduce the injection pressure
- Reduce the injection time
- Increase clamping force
- Inspect the mold for irregularities
- Reduce the melt temperature
- Inspect vent depth
- Switch to higher tonnage clamping machine
- Establish correct transfer position
- Reduce hold pressure

Parts Surface has Jetting

The finished product exhibits serpentine flow patterns on the surface as a result of the melt cooling prior to complete filling of the mold.

Probable Cause:

Molding Machine



- High injection speed



Mold



- Cold mold
- Small gate
- Wrong gate land length
- Wrong gate location



Material



- Cold melt



Solution (In sequence):



- Decrease injection speed
- Verify nozzle temperature
- Increase mold temperature
- Increase melt temperature
- Increase gate size
- Modify gate location

Parts are Pitted

The finished product contains unmelted particles or small holes on the surface.

Probable Cause:

Molding Machine



- Improper or worn out feed screw
- Low melt temperature
- Low injection speed

Mold



- Gating shear
- Sharp corners

Material



- Resin used is not homogeneous
- External contamination

Solution: (In sequence)



- Reduce shear
- Reduce back pressure
- Reduce injection speed
- Modify temperature
- Modify regrind ratio
- Modify shot size
- Inspect hot runner and nozzles



Parts Surface is Rough

The finished product exhibits patterns on the surface similar to grooves on a record, due to rapid cooling of the melt as it nears mold surface, followed over and over again by fresh melt.

Probable Cause:

Molding Machine



- Low injection speed
- Low injection pressure

Mold

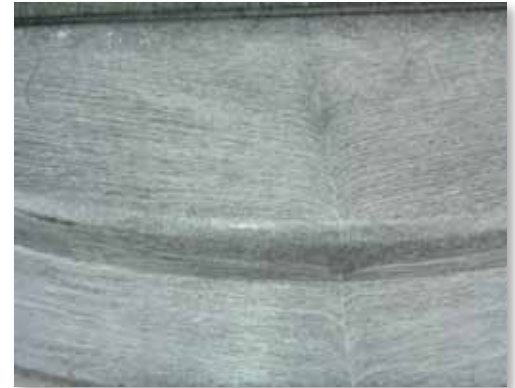


- Cold mold
- Irregularities in mold surface; defective polishing

Material



- Cold melt



Solution (In sequence):



- Increase injection speed
- Increase injection pressure
- Increase melt temperature
- Increase mold temperature
- Inspect mold surface

Parts are Sticking to Cavity

The finished product does not properly release from the mold (female side).

Probable Cause:

Molding Machine



- High injection pressure
- High injection speed
- Long holding time
- High material feed

Mold



- Hot cavity
- Cold mold
- Defective mold surface

Material



- Melt too hot

Solution: (In sequence)



- Confirm cycle time for cooling
- Reduce injection pressure
- Reduce injection hold time
- Reduce injection speed
- Reduce injection time
- Adjust feed
- Inspect mold finish
- Increase mold opening cycle
- Lower mold temperature
- Adjust differential temperatures
- Inspect for appropriate mold release



Parts are Sticking to Core

The finished product does not properly release from the mold (male side).

Probable Cause:

Molding Machine

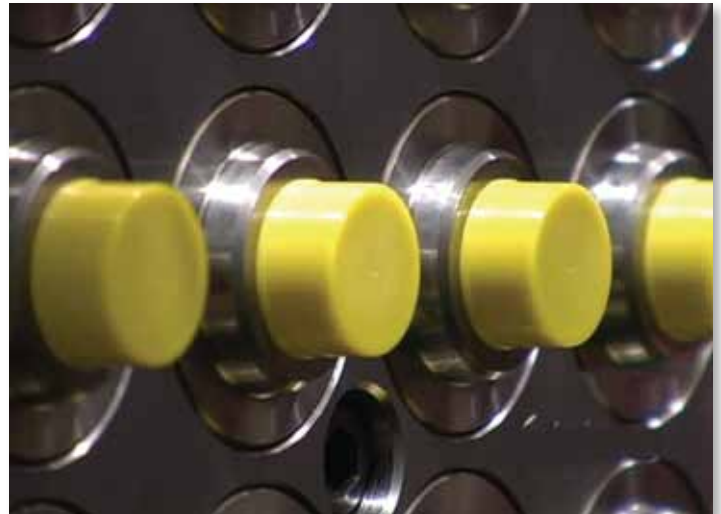


- High injection pressure

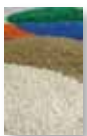
Mold



- Hot core
- Bending of core
- Presence of vacuum



Material



- Generally not a material related issue

Solution (In sequence):



- Confirm cycle time for cooling
- Reduce injection pressure
- Reduce injection hold time
- Reduce injection time
- Adjust feed
- Reduce mold closed time
- Increase core temperature
- Decrease nozzle temperature
- Inspect mold for undercuts and/or improper draft
- Verify mold bending ratio

Parts are Short

The finished product is not completely formed.

Probable Cause:

Molding Machine



- Bad feed
- Low injection pressure
- Low injection speed
- Short injection time
- Back flow valve or check ring faulty
- Improper venting



Mold



- Insufficient venting
- Cold mold

Material



- Low melt temperature
- Viscous material

Solution (In sequence):



- Increase feed
- Increase injection pressure
- Increase feed temperature by increasing cylinder temperature
- Increase injection time
- Increase mold temperature
- Increase nozzle diameter
- Inspect for restrictions
- Increase gate size of sprue and runner system

Parts have Sinks or Voids

The finished product has hollows and pockets in areas that do not cool sufficiently, causing contraction.

Probable Cause:

Molding Machine



- Low injection pressure
- Short injection time
- Insufficient material in cavity
- High injection speed
- Low back pressure
- Damaged backflow valve / check ring

Mold



- Mold not at required temperature
- Small gate leading to early freezing
- Gate land length too long
- Incorrect rib/wall dimensions
- Material flow incorrect
- Thick wall part



Material



- Hot material
- Material wrong grade for application

Solution: (In sequence)



- Adjust injection speed
- Increase injection hold time
- Increase injection pressure
- Adjust melt temperature
- Adjust mold temperature
- Inspect for hot spots
- Enlarge and/or add vents to mold parting line
- Increase sprue or runner size
- Increase gate size/reduce gate land length
- Relocate gate closer to heavy/thicker areas
- If possible, core out heavy wall sections

Parts Display Splay

The finished product display splay/splash marks and/or silver streaks.

Probable Cause:

Molding Machine



- Resin degraded from overheating
- Cylinder contains hot spots
- Material trapped at nozzle tip
- Wrong injection pressure
- Wrong injection speed
- Low back pressure



Mold



- Friction related burning in gate, nozzle or hot runner
- Trapped volatile compounds



Material



- Hot melt
- Contaminated resin (moisture, dirt, organics)
- Degraded resin

Solution (In sequence):



- Dry resin according to procedure; check drying equipment for functionality
- Reduce nozzle temperature
- Reduce material temperature:
 1. lower cylinder temperature;
 2. reduce screw speed;
 3. reduce back pressure
- Decrease injection speed
- Increase mold temperature
- Decrease or eliminate screw decompression
- Reduce cycle time
- Check for drooling
- Check for contamination in mold cavity
- Open gates
- Try mold in smaller shot-size press

Parts are Streaked

The finished product has large, dull and laminate appearance areas on the surface.

Probable Cause:

Molding Machine



- Back flow valve ring damaged

Mold



- Hot spots
- Material trapped in certain areas

Material



- Contamination of resin or machine
- If pattern is identical, cause may be the machine
- If pattern is erratic, cause may be the material or coloring
- Degraded or unstable material

Solution: (In sequence)



- Check for contamination
- Check barrel purging
- Inspect back flow ring for wear or cracks
- Inspect feed screw for wear and tear
- Inspect screw/barrel for tolerances
- Verify heater operation
- Verify thermocouple operation



Parts are Stringing

The finished product has thin plastic strings attached to the sprue.

Probable Cause:

Molding Machine



- High back pressure
- High nozzle temperature

Mold



- Incorrect sprue

Material



- Melt strength inadequate

Solution (In sequence):



- Reduce back pressure
- Modify nozzle temperature
- Modify temperature profile
- Eliminate sprue breaks
- Increase cooling time
- Decrease mold temperature at the gate



Parts are Warped

The finished product has pressure differences/stress on its surface, causing the part to be disfigured.

Probable Cause:

Molding Machine



- Wrong cooling time
- High injection pressure

Mold



- Gate located in wrong area
- Undercuts too big
- Cavity too hot
- Part is wrong design or too heavy

Material



- Fillers have wrong orientation
- Incorrect material

Solution (In sequence):



- Ensure temperature in both mold halves is equal
- Monitor part ejection from mold for uniformity
- Monitor part handling following ejection
- Verify part weight following ejection
- Increase injection hold time
- Increase cooling time
- Adjust injection pressure
- Adjust mold temperature; set sequential temperatures based on part geometry
- Check gate dimensions, quantities and locations
- Re-design part if necessary



Parts have Weld Lines

The finished product has lines where two flow fronts meet and have not fused, creating the possibility of weak areas and stress fractures.

Probable Cause:

Molding Machine



- Low injection speed
- Low injection pressure
- Short injection time forward



Mold



- Low mold temperature
- Poor venting
- Back flow valve / check ring malfunctioning
- Gates too far apart
- Redesign part

Material



- Cold melt
- Material wrong grade for application

Solution: (In sequence)



- Increase injection pressure
- Increase injection holding time
- Increase injection speed
- Increase cylinder temperature
- Increase mold temperature
- Check for venting
- Provide an overflow well adjacent to the weld area
- Modify the gate location
- Decrease gate land length

Section 17 - Glossary of Terms

- **Aspect Ratio:** Ratio of total flow length to average wall thickness.
- **Back Pressure:** The pressure applied to the plastic during screw recovery. By increasing back pressure, mixing and plasticating are improved; however, screw recovery rates are reduced.
- **Backplate:** Inlet component to the hot runner manifold.
- **Barrel:** The part of the mold- ing press where resin is melted.
- **B-Side:** The mold half that mounts to the moving side of the injection molding press. Sometimes referred to as the core side of the mold or the cold half, the B-Side has ejector pins to push the part out of the open mold. An analysis of the part geometry determines the optimal part orientation to ensure that it will remain on the B-Side when the mold is opened
- **Clamp Force:** The force required to hold the mold shut so resin cannot escape during injection.
- **Contoured Pins:** Ejector pins with the ends shaped to match a sloping surface on the part.
- **Core:** A convex feature on either side of the mold that will enter an opposing cavity when the mold is closed. The void between the cavity and core is where the resin solidifies and forms the part. Often the B-side of a mold is referred to as the core side.
- **Core-cavity:** The design of a mold where the A-side forms the outside of the part and the B-side forms the inside. The advantage to this approach is that the part will shrink onto the B-side so it can be ejected, and if the inside and outside are drafted with equal and opposite draft the wall thickness will be constant.
- **Cycle Time:** The time it takes to make one part including the closing of the mold, the injection of the resin, the solidification of the part, the opening of the mold and the ejection of the part.
- **Cavity:** The space inside a mold into which material is injected.
- **Clamp:** The part of an injection molding machine incorporating the platens that provides the force necessary to hold the mold closed during injection of the molten resin and open the mold to eject the molded part.
- **Clamping Plate:** A plate fitted to a mold and used to fasten the mold to a platen.
- **Clamping Pressure:** The pressure applied to the mold to keep it closed during a cycle, usually expressed in tons.
- **Closed-loop Control:** System for monitoring complete, injection molding- process conditions of temperature, pressure and time, and automatically making any changes required to keep part production within preset tolerances.
- **Cooling Channels:** Channels located within the body of a mold through which a cooling medium is circulated to control the mold surface temperature.
- **Cushion:** Extra material left in barrel during cycle to try and ensure that the part is packed out during the hold time.
- **Cycle:** The complete sequence of operations in a process to complete one set of moldings. The cycle is taken at a point in the operation and ends when this point is again reached and moving platens of the clamp unit in the fully open position.
- **Cycle Time:** The time required by an injection molding system to mold a part.
- **Dwell:** A pause in the applied pressure to a mold during the injection cycle just before the mold is completely closed. This dwell allows any gases formed or present to escape from the molding material.
- **Ejector Pins:** Pins that are pushed into a mold cavity from the rear as the mold opens to force the finished part out of the mold. Also called knockout pins.
- **Ejector Return Pins:** Projections that push the ejector assembly back as the mold closes. Also called surface pins or return pins.
- **Ejector Rod:** A bar that actuates the ejector assembly when the mold opens.
- **Family Mold:** A multi-cavity mold where each of the cavities forms one of the component parts of an assembled finished part.
- **Fill:** The packing of the cavity or cavities of the mold as required to give a complete part or parts that are free of flash.
- **Flow:** A qualitative description of the fluidity of a plastic material during the process of molding. A measure of its moldability generally expressed as melt flow rate or melt index.
- **Gate:** An orifice through which the melt enters the mold cavity.
- **Hot Tip Gate:** An injection molding method that uses a heated gate on the A-side of the part to eliminate the creation of any runner or sprue. The gate vestige will be a small sharp bump that can be trimmed if necessary.

- **Hot Runner Mold:** A mold in which the runners are insulated from the chilled cavities and are kept hot. Hot runner molds make parts that have no scrap.
- **Injection:** The process of forcing melted resin into a mold.
- **Injection Pressure:** The pressure on the face of the injection screw or ram when injecting material into the mold, usually expressed in PSI OR BAR.
- **Knockout Pins:** A rod or device for knocking a finished part out of a mold.
- **L/D Ratio:** A term used to help define an injection screw. This is the screw length-to-diameter ratio.
- **Manifolds:** distribute melt from the inlet component to one or more sub-manifolds WITHIN A HOT RUNNER.
- **Melt Flow Rate:** A measure of the molten viscosity of a polymer determined by the weight of polymer extruded through an orifice under specified conditions of pressure and temperature. Particular conditions are dependent upon the type of polymer being tested. MFR usually is reported in grams per 10 minutes. Melt flow rate defines the flow of a polypropylene resin. An extrusion weight of 2160 grams at 446°F (230°C) is used.
- **Melt Flow Index:** Term that defines the melt flow rate of a polyethylene resin. An extrusion weight of 2160 grams at 310°F (190°C) is used.
- **Mold:** A series of machined steel plates containing cavities into which plastic resin is injected to form a part.
- **Mold Frame:** A series of steel plates which contain mold components, including cavities, cores, runner system, cooling system, ejection system, etc.
- **Mold-Temperature-Control Unit:** Auxiliary equipment used to control Hot Runner temperature. Some units can both heat and cool the mold. Others, called chillers, only cool the mold.
- **Moving Platen:** The platen of an injection molding machine that is moved by a hydraulic ram or mechanical toggle.
- **Multi-Cavity Mold:** A mold having two or more impressions for forming finished items in one machine cycle.
- **Multi-Material Molding:** The injection of two-or-more materials, in sequence, into a single mold during a single molding cycle. The injection molding machine is equipped with two-or-more plasticators. (See also co-injection)
- **Nest Plate:** A retainer plate in the mold with a depressed area for cavity blocks.
- **Non-Fill:** See short shot.
- **Non-Return Valve:** Screw tip that allows for material to flow in one direction and closes to prevent back flow and inject material into the mold.
- **Machine Nozzle:** The hollow-cored, metal nose screwed into the injection end of a plasticator. The nozzle matches the depression in the mold. This nozzle allows transfer of the melt from the plasticator to the runner system and cavities.
- **Packing:** The filling of the mold cavity or cavities as full as possible without causing undue stress on the molds or causing flash to appear on the finished parts. Over- or under-packing results in less than optimum fill.
- **PET:** Polyethylene Terephthalate, a type of polyester and a leading recyclable plastic material.
- **Pinpoint Gate:** A restricted gate of 0.030 in or less in diameter, this gate is common on hot runner molds.
- **Platens:** The mounting plates of a press on which the mold halves are attached.
- **Preform:** A plastic test tube shaped part produced by injection molding systems in the first step of a two-stage injection molding and blow molding process used to produce PET bottles or containers. The preform is subsequently re-heated and stretch blown through a blow molding process into the final container shape.
- **Pressure Disk:** Manifold component designed to be compressed by thermal expansive forces to form part of the plastic sealing mechanism. Also helps to reduce thermal transfer to a minimum.
- **Process:** The injection molding environment consisting of input variables such as temperature, pressure, injection rates and time that are controlled to fill the mold while optimizing the trade-offs between cosmetics and dimensional accuracy.
- **Ram:** The forward motion of the screw in the barrel that forces the melt into the mold cavity.
- **Recovery Time:** The length of time for the screw to rotate and create a shot.
- **Restricted Gate:** A very small orifice between runner and cavity in an injection mold. When the part is ejected, this gate readily breaks free of the runner system. Generally, the part drops through one chute and the runner system through another leading to a granulator and scrap reclaim system.
- **Retainer Plate:** The plate on which demountable pieces, such as mold cavities, ejector pins, guide pins and bushings are mounted during molding.

- **Ring Gate:** Used on some cylindrical shapes. This gate encircles the core to permit the melt to first move around the core before filling the cavity.
- **Runner:** The channel that connects the sprue with the gate for transferring the melt to the cavities.
- **Runnerless Molding:** See hot runner mold.
- **Screw Travel:** The distance the screw travels forward when filling the mold cavity.
- **Shear:** The force between layers of resin as they slide against each other or the surface of the mold. The resulting friction causes some heating of the resin.
- **Short Shot:** Failure to completely fill the part or cavities of the mold. Edges may appear melted.
- **Shot:** The complete amount of melt injected during a molding cycle, including that which fills the runner system.
- **Shot Capacity:** Generally based on polystyrene, this is the maximum weight of plastic that can be displaced or injected by a single injection stroke. Generally expressed as ounces of polystyrene.
- **Single-Cavity Mold:** A mold having only one cavity and producing only one finished part per cycle.
- **Sprue Bushing:** A hardened-steel insert in the mold that accepts the Screw nozzle and provides an opening for transferring the melt.
- **Sprue Gate:** A passageway through which melt flows from the nozzle to the mold cavity.
- **Sprue:** The feed opening provided in injection molding between the nozzle and cavity or runner system.
- **Stationary Platen:** The large front plate of an injection molding press to which the front plate of the mold is secured. This platen does not move during normal operation.
- **Thermoplastic:** A polymer which melts or flows when heated. Thermoplastic polymers are usually not highly cross-linked, and act much like molecular solids: low melting and boiling points, high ductile strength.
- **Thermoset:** A polymer that doesn't melt when heated. Thermoset polymers "set" into a given shape when first made and afterwards do not flow or melt, but rather decompose upon heating. They are often highly cross-linked polymers, with properties similar to those of network covalent solids, i.e., hard and strong.
- **Valve Disk:** Manifold component designed to be compressed by thermal expansive forces to form part of the plastic sealing mechanism. It's high tolerance bore allows the valve pin to shift through it without plastic leakage and part of it enters the melt stream and helps guide the plastic flow without stagnation.
- **Valve Gating:** An injection molding method that uses a mechanical shut off to open and close the gate orifice.
- **Vent:** A shallow channel or opening cut in the cavity to allow air or gases to escape as the melt fills the cavity.
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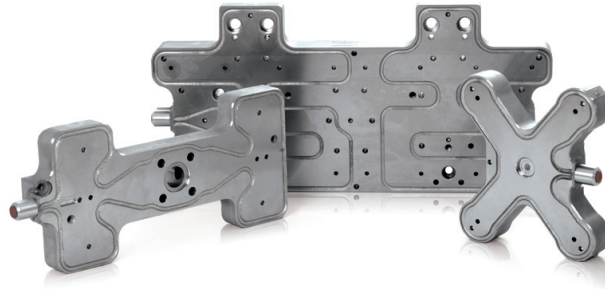
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NOTE TO MOLD MAKER:

This detailed user manual has been prepared to assist in the integration, processing and troubleshooting of your *Mold-Masters®* System.

When this hot runner system has been integrated into the mold, please ensure that this user manual is forwarded to the molder / end user together with the mold.

www.moldmasters.com



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